

# AMSCO Maintenance Manual



**2080L/2080RC/2080RC I.A./2080 COMPAT IV  
SURGICAL TABLES**

**(8/87)**

**P-754234-091**

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## SUMMARY OF SAFETY PRECAUTIONS

The following are personnel (WARNINGS) and equipment (CAUTIONS) **safety precautions** to be observed when operating or servicing this unit. This is a summary listing of safety precautions appearing in the text. Carefully read them before proceeding to use or service the unit. The precautions are repeated where applicable throughout the manual. Observance of these safety precautions will minimize the risk of personal injury or the possible use of improper maintenance methods which may damage the unit or render it unsafe. It is important to understand that these precautions are not exhaustive. AMSCO could not possibly know, evaluate and advise maintenance departments of all conceivable ways in which maintenance might be done or the possible hazardous consequences of each way.

The operation and maintenance procedures recommended by AMSCO are described in this manual. Only these recommended maintenance procedures should be followed.

### WARNINGS:

**REPAIRS AND ADJUSTMENTS SHOULD BE ATTEMPTED ONLY BY EXPERIENCED TECHNICIANS FULLY ACQUAINTED WITH THIS EQUIPMENT. USE OF INEXPERIENCED, UNQUALIFIED PERSONS TO WORK ON THE EQUIPMENT OR THE INSTALLATION OF UNAUTHORIZED PARTS COULD CAUSE INJURY OR RESULT IN COSTLY DAMAGE.**

**TIPPING HAZARD. DO NOT OPERATE THIS TABLE WITHOUT ENGAGING FLOOR LOCKS.**

**ENSURE TABLETOP IS PROPERLY SUPPORTED BEFORE PERFORMING ANY MAINTENANCE REQUIRING THE TABLETOP TO BE MAINTAINED IN THE "RAISED" POSITION.**

**CRUSHING HAZARD. CAUTIOUSLY LOWER LEG SECTION OR POSITION TABLE IN REVERSE TRENDLENBURG WHEN HEAD/FOOT SECTION IS EXTENDED.**

**DISCONNECT POWER AT WALL DISCONNECT BOX PRIOR TO INSPECTING AND CLEANING ANY ELECTRICAL CONTACTS.**

### CAUTIONS:

**Forcing the power pedal during emergency operation without first positioning one of the control levers exerts undue strain on the power pedal shaft and mechanism. This should be avoided.**

**Do not open flow-control valve more than 1/2 turn as it may cause loss of pressure in the hydraulic system. If adjustment procedure does not correct the problem, replace the valve.**

**Do not mix different brands of hydraulic oil. Recommended hydraulic oil — Chevron AW32.**

**During Cam and Roller adjustment, eccentric nuts should be tightened only with slight wrench pressure. Excessive tightening will fracture eccentric at flange.**

## **CHAPTER A**

### **GENERAL INFORMATION**

#### **A-1 APPLICATION AND DESIGN**

The product literature included in this section contains technical data relating to the principal descriptive and identifying characteristics of particulars for surgical tables. The literature is informational rather than instructional. It provides, textually and illustratively, a general concept of the equipment, its purpose, capabilities, limitations, and technical specifications.

The following information should be included in this Section:

SD-159

SD-211

SD-212

SD-321



**AMSCO**

AN EMPLOYEE OWNED COMPANY

## APPLICATION

These Tables provide flexible articulated posturing of the surgical patient, assuring maximum operative convenience.

## DESIGN AND CONSTRUCTION

**General.** Both the 2080L and 2080RC tables comply with the *Radiation Control for Health and Safety Act* of October 18, 1968. They are also certified by Canadian Standards Association to CSA Standard C22.2, No. 125 — 1979 — Electromedical Equipment. They are electro-hydraulically operated for easy positioning. The 2080RC offers, in addition to its lever-operated control system, "Touch Command" ... for precise positioning of the table from outside the surgical field.

**NOTE:** The 2080L conforms with requirements set forth in *National Fire Protection Association's Pamphlet 56A*. It is also listed by Underwriters Laboratories as being safe for use in Class I, Group C hazardous locations, including the requirements of UL Standard 544.

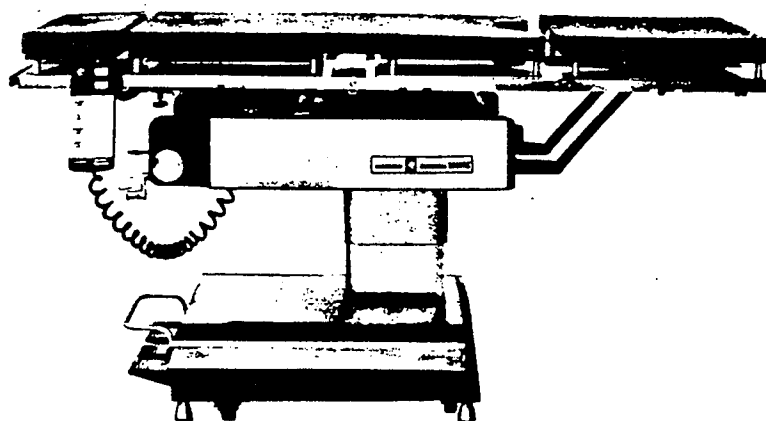
**Base** is cast iron with textured-enamel finish. The top is enclosed by a welded, stainless-steel cover that also forms a shroud for the lower portion of the pedestal. A swivel caster and height-adjustable floor lock at each corner of the base are actuated by a single pedal. Both are electrically conductive, conforming with applicable requirements of NFPA's publication *Flammable Anesthetics Code*. The base provides comfortable toe space on both sides as well as space to freely insert a flat-blade Mayo stand. A NFPA-approved patient grounding

## 2080 SERIES\* Major Surgical Tables

• 2080L

• 2080RC

## TECH DATA



(Model 2080RC Table Shown)

\*pat. pending

Typical only — some details may vary.

receptacle is provided at foot-end of base.

**Hydraulic System** is also contained within the base assembly. The electro-hydraulic pump and motor assembly forms a straight-line sealed unit; the motor includes overload protection. An auxiliary pump provides manual operation in event of electrical power failure, without sacrificing table-positioning flexibility.

**Pedestal** includes tabletop lift cylinder, support column with bearing-mounted saddle frame, hydraulic piping, and electrical wiring (2080RC only). These are fully enclosed by stainless-steel telescoping shrouds.

## THE SELECTIONS CHECKED BELOW APPLY TO THIS EQUIPMENT

### Model

- ☐ 2080RC
- ☐ 2080L

### Options

- ☐ Table with 2" (51mm) thick Pad
- ☐ Table with Radiographic Top and 1" (25mm) thick Pad
- ☐ Table with Radiographic Top and 2" (51mm) thick Pad
- ☐ Accessories (see separate product literature)

Item No. \_\_\_\_\_  
Location(s) \_\_\_\_\_

2080 Surgical Table Series



Each shroud is one-piece construction to ensure against foreign matter entering the elevating mechanism.

**Superstructure** includes gears, motors and other devices required to position and articulate the tabletop. The frame is cast aluminum finished with textured-enamel paint. The superstructure is bearing-mounted to the elevating mechanism and power-assisted to handle heavy loads with ease. Indicators show degree of lateral tilt and Trendelenburg.

Positioning mechanism is fully enclosed by stainless-steel covers to prevent entanglement of drapes. Power-assisted movements are quick, smooth and precise. There's built-in safety to prevent accidental movement.

**Tabletop.** The 20-inch (508-mm) wide tabletop (see page 4) is divided into four hinged sections: head, back, seat, and foot. Each section is cast aluminum (back, seat and foot sections are covered by stainless-steel veneer). Drilled holes are included for the optional radiographic top. Stainless-steel side rails, notched to receive optional accessories, extend the full length (also the superior edge of head rest on the 2080RC). Mounting hardware and a full complement of optional accessories are available ... see separate product literature.

The foot and back sections are safely supported by two hinged, steel lever arms.

The tabletop is bearing-mounted to the superstructure at the seat section. The seat and foot sections include a perineal cutout for full access to the patient and to accommodate the optional transurethral drain tray. The tabletop (with exception of the head section) is electro-hydraulically positioned by gear-actuated lever linkage. The head section is secured by a manual, spring-loaded, ratchet mechanism. The head section may also be removed and positioned longitudinally to extend table length by as much as 6 inches (152mm), or it may be attached to the foot section for procedures requiring extended foot support. A Velcro<sup>®</sup> (Velcro Corporation) tape strip on the longitudinal centerline of the head, back and foot sections permits instant application and removal of mattress pads ... no other pad-fastening devices are required.

An independently operated kidney elevator is centrally located between the back and seat sections. The elevator is raised and lowered by a crank and dual rack and pinion mechanism, operating in conjunction with the gearing and jointed drive shaft. The kidney elevator is cast aluminum covered by stainless-steel veneer.

**Optional Radiographic Top** is constructed of permeable phenolic and is electrically conductive. It mounts on full width and length of tabletop. The radiographic top complies with the *Radiation Control for Health and Safety Act* of October 18, 1968. A 14x17 inch (356x432mm) radiographic cassette can be inserted from head- or foot-end; 12x14 inch (305x356mm) radiographic cassette, from side, head-end or foot-end. (Radiographic cassettes are not furnished by AMSCO.)

## OPERATING CONTROLS

Control actuators and selectors requiring operator attention are at the head-end of the table, easily accessible to the anesthetist.

**Foot Pedals** feature low-profile design ... do not obstruct the surgeons' approach. They include:

- **LOCK** — to engage either the casters or locks with the floor.
- **LOWER** — to lower the tabletop.
- **RAISE** — to raise the tabletop.
- **POWER** — to (1) energize the hydraulic pump, (2) serve as a safety device to avoid accidental movement of the tabletop, and (3) allow manual pumping of the hydraulic system should electric power fail.

**Tabletop Positioning Controls** are mounted at a convenient height on the superstructure ... arranged for simple, accurate actuation. After setting the selector for the desired movement, the tabletop is positioned by operating the POWER pedal and control actuator. Actuators return to neutral upon release. Selections include:

- **TRENDELENBURG** — to lower or raise the head-end of the superstructure from horizontal, to achieve Trendelenburg (head down) and reverse Trendelen-

burg (head up). Control is on left side of head end.

- **BACK** — to lower or raise the back section.
- **SIDE** — to laterally tilt the superstructure to the right or left.
- **FOOT** — to lower or raise the foot section.
- **FLEX** — to simultaneously position the back and seat sections so as to achieve an inverted "V" (flex) or "V" (reflex) position.

## REMOTE CONTROL (2080RC ONLY)

The Remote Control Unit is hand-held ... outside of the surgical field. It controls the raising, lowering and positioning of the tabletop electro-hydraulically as previously described. The control is connected to the table by a coiled rubber cord approximately 4 feet (1219mm) long. The control is lightweight and, when not in use, clips anywhere along table side and head rails. Six clearly indicated rocker switches are double-acting and self-neutralizing ... this means easy, fingertip operation. Unmistakable power push buttons must be energized simultaneously with selector switch, thus providing dual safety control. A power indicating light signals when table is energized.

## ACCESSORIES

*See separate product literature.*

## MATERIAL SPECIFICATIONS

**General.** Materials not definitely specified herein are of the best quality routinely employed for the purpose in the industry. They have been selected to help enhance the safety, serviceability and appearance of the finished product.

**Finish.** Exposed stainless steel (conforming with ASTM Specification A 167), aluminum and chromium-plated surfaces are polished. Cast iron and carbon-steel exterior surfaces are degreased, phosphatized and coated with corrosion-resistant primer followed by two spray coats of textured-enamel paint. The finish is then oven baked.

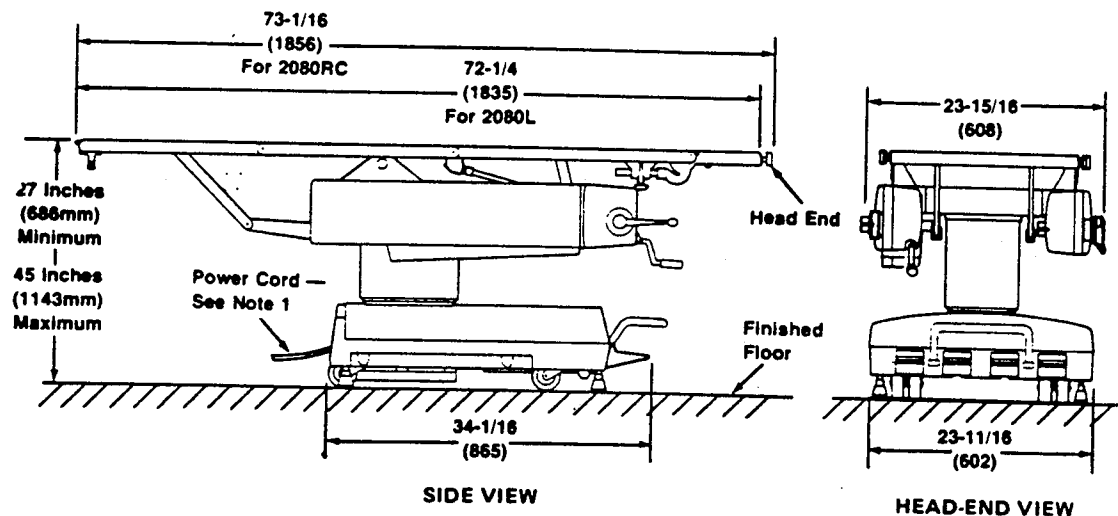
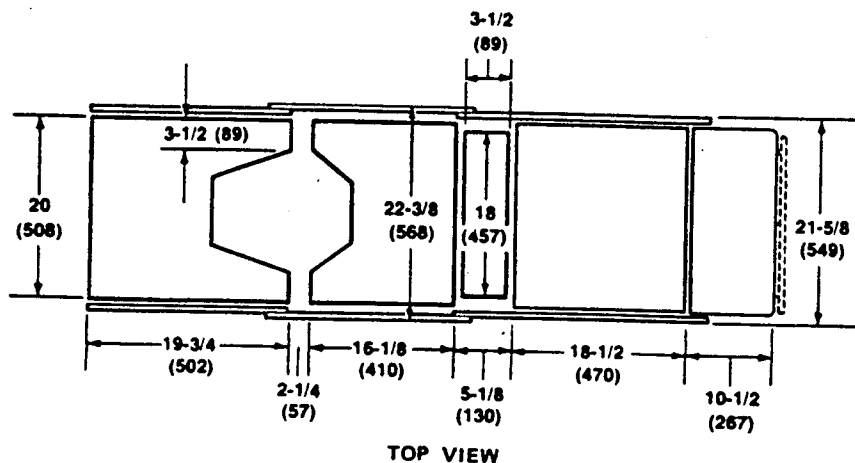
## PERFORMANCE CAPABILITIES

When operated with a 300-pound (136-kg) load distributed as follows: 25 lbs (11.4 kg) on the head section, 100 lbs (45.4 kg) on back section, 140 lbs (63.6 kg) on seat section and 35 lbs (15.9 kg) on foot section; the table shall be positioned as follows without perceptible binding or jerking, and without settling after the positions are obtained.

Table Component	Position Starting With Superstructure Horizontal	Range
Top and Superstructure	Raise — Lower	To any point within 27 to 45 inches (686 to 1143mm) above the floor.
	Trendelenburg (head down)	0 to 20°
	Reverse Trendelenburg (head up)	0 to 20°
	Tilt to Right	0 to 10°
	Tilt to Left	0 to 10°
Head Section	Raise (from horizontal)	0 to 90°
	Lower (from horizontal)	0 to 90°
Back Section	Raise	0 to 90°
	Lower	0 to 10°
	*Flex	0 to 15°
	*Reflex	0 to 10°
Seat Section	*Flex	0 to 20°
	*Reflex	0 to 15°
Foot Section	Lower (with Seat Section horizontal)	0 to 105°
Kidney Elevator	Raise (from tabletop level)	approx 4 1/2 inches (114mm)

\*Flex and Reflex positioning involves simultaneous movement of Back, Seat and Foot sections.

**IMPORTANT:** AMSCO table products are designed to safely support and position a 300-pound patient with body weight appropriately distributed to attain standard surgical positions typical of those shown in AMSCO literature. This same design criteria is applied to AMSCO accessories used with tables of our manufacture.



**DIMENSIONS ARE INCHES (MILLIMETERS) — DRAWING IS NOT TO SCALE**

**NOTES:**

1. Provide 120-volt, 60-Hz, 10-amp electric service. Approximately 15-foot (4572-mm) long, No. 16, 3-conductor cord with Hubbell hospital-grade plug is provided on 2080RC (THIS TABLE IS NOT TO BE USED IN THE PRESENCE OF FLAMMABLE ANESTHETICS).

An explosionproof plug approved for use by Underwriters Laboratories in Class I Group C locations must be attached to 2080L by customer.

2. Approximate weight — 820 lbs (372 kg).
3. Male connector to ground patient is not furnished by AMSCO.

This print is for guidance when planning space and utility services. Actual installation prints may be obtained from any AMSCO office or representative.



# AMSCO

## PIVOT MOUNT for COMPAT IV Image Intensification Compatible Tables

## TECH DATA

SD-211R

(9/79)

### APPLICATION

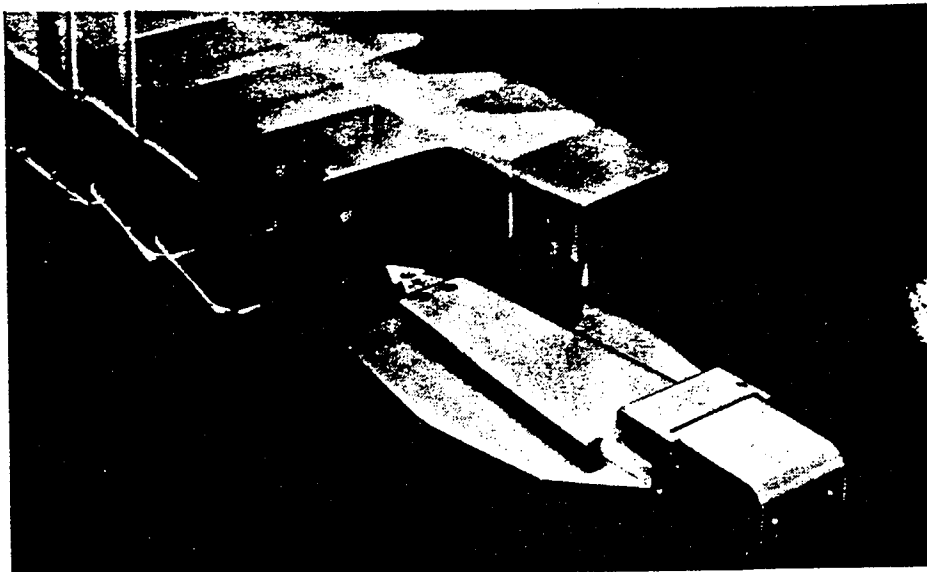
To be permanently installed in an O.R. thereby permitting the use of specially designed surgical tables which can be moved into or out of the O.R. as their need dictates. In addition to providing maximum flexibility, this system also features the advantages of fixed-base tables.

### DESIGN AND CONSTRUCTION

**General.** The pivot mount is water-proof and shock free, there are no exposed cables. The entire system is designed for operation on 110- to 125-volts, 60-Hz, single-phase service in accordance with NFPA 56A for the use of inhalation anesthetics with respect to isolated power systems and isolation transformers. The system is listed by Underwriters Laboratories for non-hazardous locations.

**Mounting Ring.** This stainless-steel ring to which the rotating top assembly will be fastened is for anchoring the pivot mount to the floor. The mounting ring must be so anchored that it will provide stability of the table even when supporting a 300-pound/136.1 kg load distributed over the following sections: head (25 lbs/11.34 kg), back (100 lbs/45.36 kg), seat (140 lbs/63.5 kg) and foot (35 lbs/15.88 kg). For new construction or for existing concrete floors at least 5 inches (127 mm) thick, the mounting ring (as specified) will either be equipped with six steel anchors to be secured by drilling holes and cementing the anchors into them, or equipped for use with expansion bolt concrete anchors (not furnished by AMSCO). A mounting ring having four flat crimp irons to be imbedded in a concrete floor is also available for new construction.

For existing floors of less than 5 inches of concrete, the mounting ring must be installed so that the load is suitably distributed (see page 4 for table load parameters). It is the responsibility of the contractor/architect to ascertain the best installation supports. Support plates and thru floor connectors are not furnished by AMSCO.



Typical only — some details may vary.

**Top Assembly** is constructed of stainless steel. It consists of a rotating spade-like device which couples with a mating receptacle on the base of the table. The table is simply lined up with and wheeled onto the pivot where it is locked in place by spring-loaded mechanical latches. Electrical contact between the pivot mount and table is provided by physical connection of high-strength spring-loaded contacts. The contacts on the pivot are protected by a hinged stainless-steel cover that is automatically raised as the table approaches. Electrical power is supplied to the table by the contacts through an integral two-pole switch which is only actuated when the table and pivot mount are fully engaged. When the table is removed, the switch deenergizes the contacts.

The pivot assembly rotates on an integral bearing surface for easy alignment with the table; also to permit up to 360 degrees rotation starting at a point opposite the entrance to the O.R. Rotation is about a fixed axis thereby assuring proper orientation to the overhead surgical lighting fixture(s). The table is released from the pivot mount by depressing a foot pedal. Installation of the top assembly completely conceals the mounting ring and electrical connections.

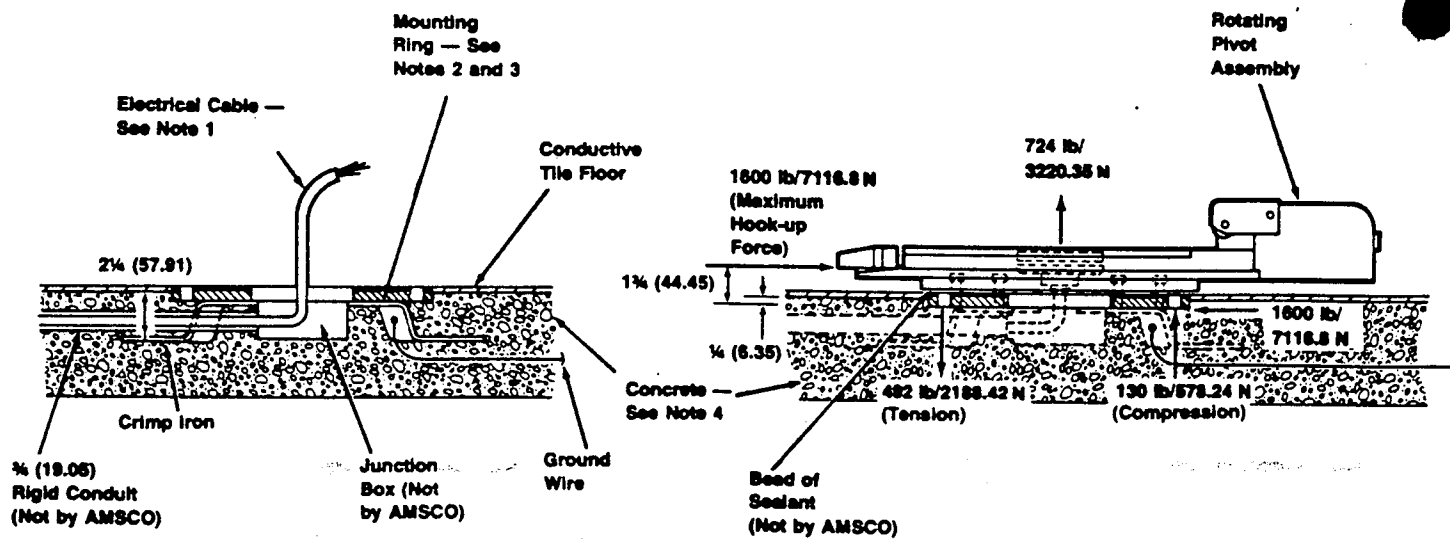
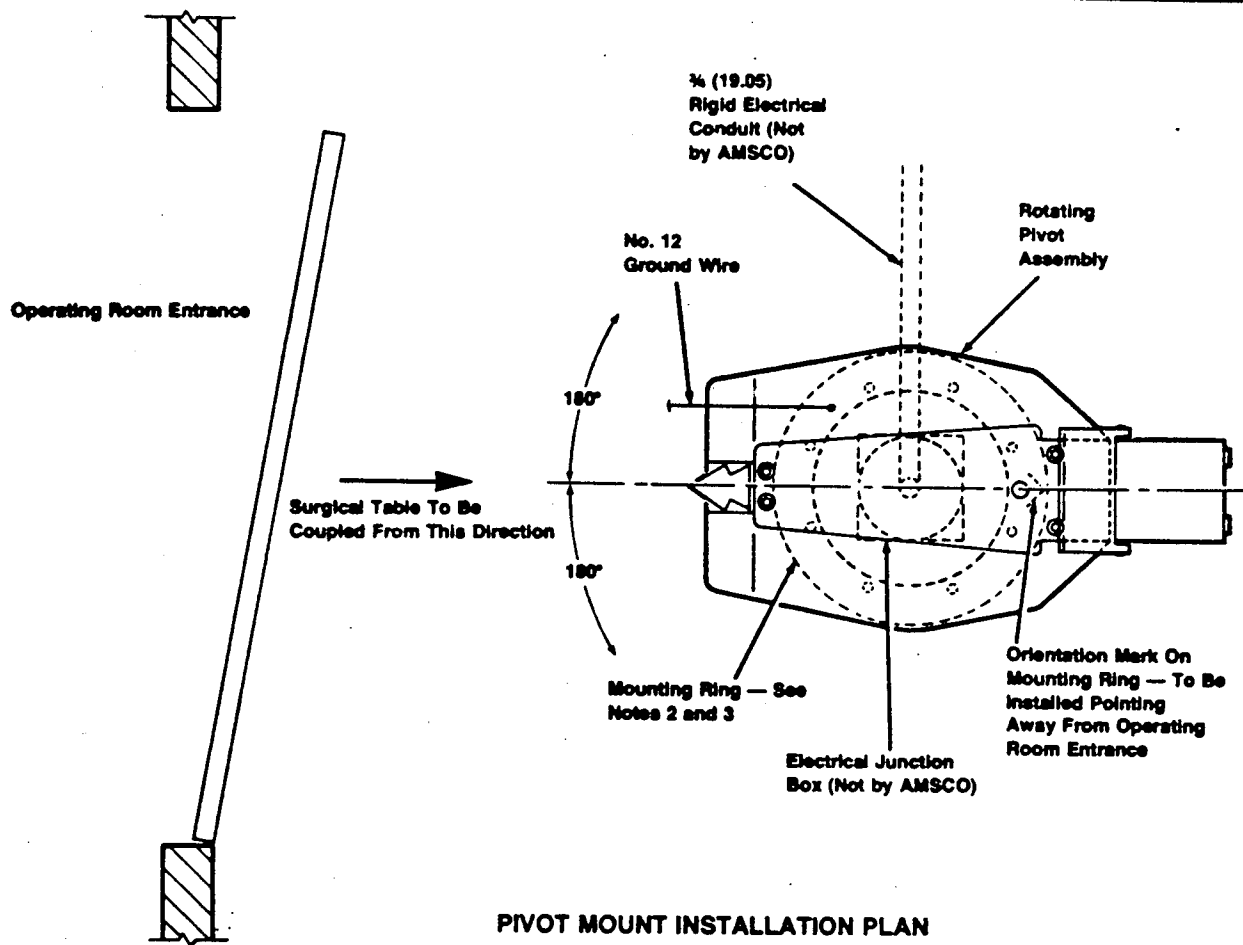
### THE SELECTION CHECKED BELOW APPLIES TO THIS EQUIPMENT

#### Fixture Equipped

- ☐ With Crimp Irons
- ☐ With Steel Anchors
- ☐ For Use With Expansion Bolt Concrete Anchors
- ☐ For Use With Thru-Floor Connectors

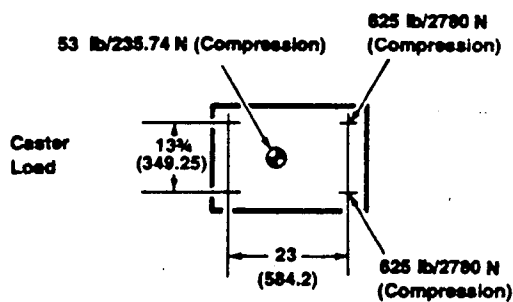
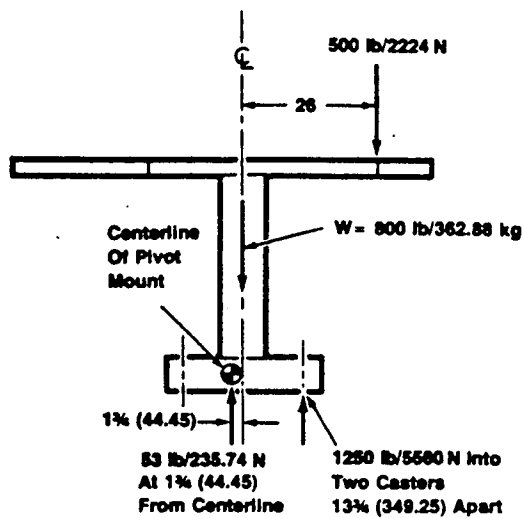
Item No. \_\_\_\_\_

Location(s) \_\_\_\_\_

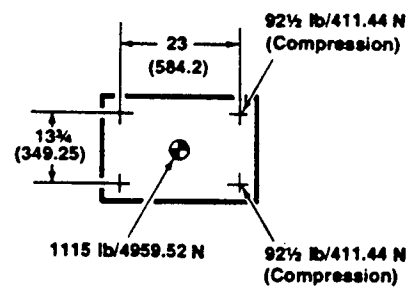
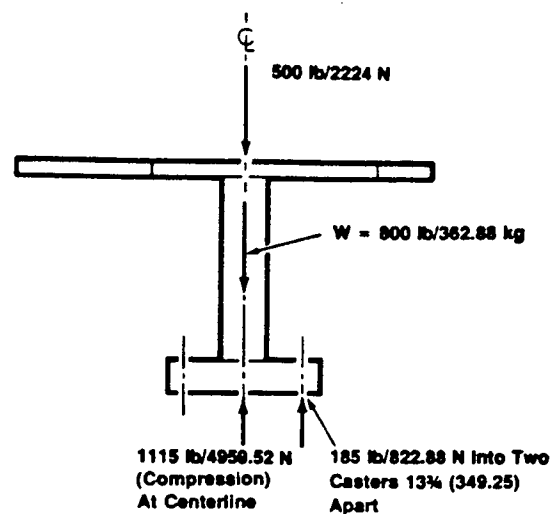


**DIMENSIONS ARE INCHES (MILLIMETERS) — DRAWINGS ARE NOT TO SCALE**





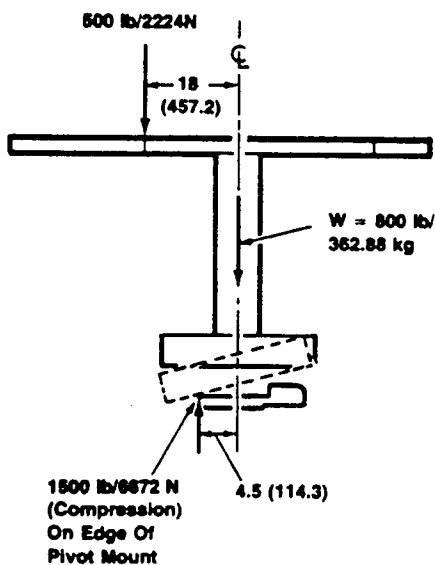
CONDITION NO. 1 — EXTERNAL LOAD APPLIED 26 INCHES (660.4 MILLIMETERS) FROM CENTERLINE OF TABLE



CONDITION NO. 2 — EXTERNAL LOAD APPLIED ON CENTERLINE OF TABLE

DIMENSIONS ARE INCHES (MILLIMETERS)

— DRAWING IS NOT TO SCALE



CONDITION NO. 3 — EXTERNAL LOAD APPLIED AT FOOT OF TABLE

#### NOTES:

1. Reaction forces shown are those necessary to maintain table in equilibrium.
2. Type of loading in parentheses indicates type of force acting on floor.

This print is for guidance when planning space and utility services. Actual installation prints may be obtained from any AMSCO office or representative.



# AMSCO

## COMPAT IV 2080 SERIES\* MAJOR SURGICAL TABLE

## TECH DATA

SD-212R2  
(5/86)

### APPLICATION

Provides extremely flexible articulated posturing of the surgical patient when performing procedures not requiring the use of image intensification. A 2080 table saves the expense of specially designed image intensification tables for every O.R., it complements the AMSCO Compat IV concept of providing a choice of tables without sacrificing the advantages of a fixed-base table.

(NOTE: The Compat IV 2080 requires a floor-mounted pivot mount ... see separate product literature for details on this special device and other Compat IV surgical tables.)

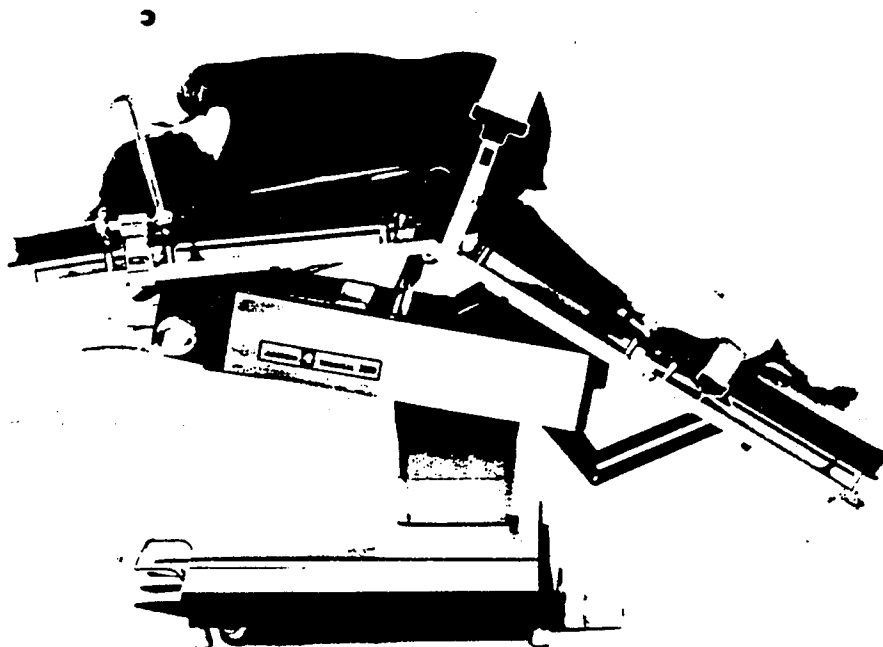
### DESIGN AND CONSTRUCTION

**General.** Complies with the Radiation Control for Health and Safety Act of October 18, 1968. The table is electro-hydraulically operated for easy positioning. The Compat IV system components, including the 2080, are listed by Underwriters Laboratories for use in non-flammable anesthetizing locations under UL standard 544.

**Base** is cast iron with textured-enamel finish. The top is enclosed by a welded, stainless-steel cover that also forms a shroud for the lower portion of the pedestal. A swivel caster and height-adjustable floor lock at each corner of the base are actuated by a single pedal. Both are electrically conductive, conforming with applicable requirements of NFPA's publication *Flammable Anesthetics Code*. The base provides comfortable toe space on both sides as well as space to freely insert a flat-blade Mayo stand.

**Pivot Mount.** The table is so equipped as to mate with a floor-mounted revolving pivot. The table is simply lined up with and wheeled onto the pivot where it automatically locks in place. Electrical power is supplied to the table through high-strength spring-loaded contacts, there is no need for loose cords. The table and pivot will rotate up to 360 degrees starting at a

\*pat. pending



Typical only — some details may vary.

point opposite the entrance to the O.R. Rotation is about a fixed axis, thereby assuring proper orientation to the overhead surgical lighting fixture(s). The table is disengaged from the pivot mount by depressing a pedal at the head end of the table.

**Pedestal** includes tabletop lift cylinder, support column with bearing-mounted saddle frame, and hydraulic piping. These are fully enclosed by stainless-steel telescoping shrouds. Each shroud is one-piece construction to ensure against foreign matter entering the elevating mechanism.

**Superstructure** includes gears, motors and other devices required to position and articulate the tabletop. The frame is cast aluminum finished with textured-enamel paint. The superstructure is bearing-mounted to the elevating mechanism and power-assisted to handle heavy loads with ease. Indicators show degree of lateral tilt and Trendelenburg.

### THE SELECTIONS CHECKED BELOW APPLY TO THIS EQUIPMENT

#### Options

- ☐ Table with 2" (50.8 mm)-thick Pad
- ☐ Table with Radiographic Top and 1" (25.4 mm) thick Pad
- ☐ Table with Radiographic Top and 2" (50.8 mm) thick Pad
- ☐ Accessories (see separate product literature)

Item No. \_\_\_\_\_  
Location(s) \_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_

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Positioning mechanism is fully enclosed by stainless-steel covers to prevent entanglement of drapes. Power-assisted movements are quick, smooth and precise. There is built-in safety to prevent accidental movement.

**Tabletop.** The 20" (508 mm)-wide tabletop (see page 4) is divided into four hinged sections: head, back, seat, and foot. Each section is cast aluminum (back, seat and foot sections are covered by stainless-steel veneer). Drilled holes are included for the optional radiographic top. Stainless-steel rails, notched to receive optional accessories, extend the full length on each side of the tabletop. Mounting hardware and a full complement of optional accessories are available ... see separate product literature.

The foot and back sections are safely supported by two hinged, steel lever arms.

The tabletop is bearing-mounted to the superstructure at the seat section. The seat and foot sections include a perineal cutout for full access to the patient and to accommodate the optional transurethral drain tray. The tabletop (with exception of the head section) is electro-hydraulically positioned by gear-actuated lever linkage. The head section is secured by a manual, spring-loaded, ratchet mechanism. The head section may also be removed and positioned longitudinally to extend table length by as much as 6 inches (152.4 mm), or it may be attached to the foot section for procedures requiring extended foot support. A Velcro® (Velcro Corporation) tape strip on the longitudinal centerline of the head, back and foot sections permits instant application and removal of mattress pads ... no other pad-fastening devices are required.

An independently operated kidney elevator is centrally located between the back and seat sections. The

elevator is raised and lowered by a crank and dual rack and pinion mechanism, operating in conjunction with the gearing and jointed drive shaft. The kidney elevator is cast aluminum covered by stainless-steel veneer.

**Optional Radiographic Top** is constructed of permeable phenolic and is electrically conductive. It mounts on full width and length of tabletop. The radiographic top complies with the *Radiation Control for Health and Safety Act* of October 18, 1968. A 14x17 inch (355.6x431.8 mm) radiographic cassette can be inserted from head- or foot-end; 12x14 inch (304.8x355.6 mm) radiographic cassette, from side, head-end or foot-end.

### OPERATING CONTROLS

Control actuators and selectors requiring operator attention are at the head-end of the table, easily accessible to the anesthetist.

**Foot Pedals** are clearly identified and adequately sized for easy use. They include:

- **LOCK** — to engage either the casters or locks with the floor.
- **LOWER** — to lower the tabletop.
- **DISENGAGE** — to release table from pivot mount.
- **RAISE** — to raise the tabletop.
- **POWER** — to (1) energize the hydraulic pump, (2) serve as a safety device to avoid accidental movement of the tabletop, and (3) allow manual pumping of the hydraulic system should electric power fail.

**Tabletop Positioning Controls** are mounted at a convenient height on the superstructure ... arranged for simple, accurate actuation. After setting the selector for the desired movement, the tabletop is positioned

by operating the POWER pedal and control actuator. Actuators return to neutral upon release. Selections include:

- **TRENDELENBURG** — to lower or raise the head-end of the superstructure from horizontal, to achieve Trendelenburg (head down) and reverse Trendelenburg (head up). Control is on left side of head end.
- **BACK** — to lower or raise the back section.
- **SIDE** — to laterally tilt the superstructure to the right or left.
- **FOOT** — to lower or raise the foot section.
- **FLEX** — to simultaneously position the back and seat sections so as to achieve an "inverted V" (flex) or "V" (reflex) position.

### ACCESSORIES

*See separate product literature.*

### MATERIAL SPECIFICATIONS

**General.** Materials not definitely specified herein are of the best quality routinely employed for the purpose in the industry. They are free of defects that might affect the safety, serviceability and appearance of the finished product.

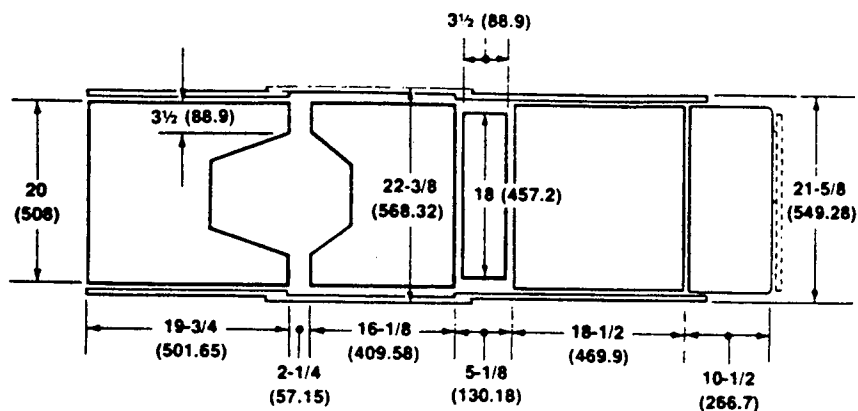
**Finish.** Exposed stainless steel (conforming with ASTM Specification A 167), aluminum and chromium-plated surfaces are polished. Cast iron and carbon-steel exterior surfaces are degreased, phosphatized and coated with corrosion-resistant primer followed by two spray coats of textured-enamel paint. The finish is then oven baked.

## PERFORMANCE CAPABILITIES

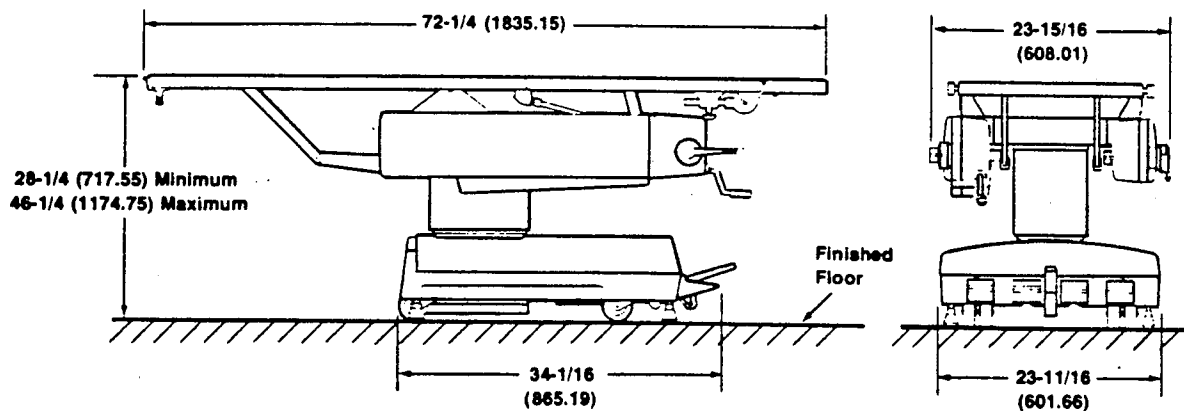
When operated with a 300-pound/136.08 kilogram load, distributed on the head (25 lbs/11.34 kg), back (100 lbs/45.36 kg), seat (140 lbs/63.5 kg) and foot (35 lbs/15.88 kg) sections, the table shall be positioned as follows without perceptible binding or jerking, and without settling after the positions are obtained. If patient weight exceeds 300 pounds, contact your AMSCO representative for further direction.

Table Component	Position Starting With Superstructure Horizontal	Range
Top and Superstructure	Raise — Lower	To any point within 28¼ to 46¼ inches (717.55 to 1174.75 mm) above the floor
	Trendelenburg (head down)	0 to 20°
	Reverse Trendelenburg (head up)	0 to 20°
	Tilt to Right	0 to 10°
	Tilt to Left	0 to 10°
Head Section	Raise (from horizontal)	0 to 90°
	Lower (from horizontal)	0 to 90°
Back Section	Raise	0 to 90°
	Lower	0 to 10°
	*Flex	0 to 15°
	*Reflex	0 to 10°
Seat Section	*Flex	0 to 20°
	*Reflex	0 to 15°
Foot Section	Lower (with Seat Section Horizontal)	0 to 105°
Kidney Elevator	Raise (from tabletop level)	approx. 4½ inches (114.3 mm)

\*Flex and Reflex positioning involves simultaneous movement of Back, Seat and Foot sections.



TOP VIEW



SIDE VIEW

HEAD-END VIEW

DIMENSIONS ARE INCHES (MILLIMETRES) — DRAWING IS NOT TO SCALE

NOTES:

1. Table is for operation on 120-volt, 60-Hz, 15-amp electric service. This service must be provided through a specially designed floor-mounted pivot mount . . . see separate product literature.
2. Approximate weight — 820 lbs/372.73 kg

This print is for guidance when planning space and utility services. Actual installation prints may be obtained from any AMSCO office or representative.



AMSCO

2080 Surgical Table Series

APPLICATION

This Table provides flexible articulated posturing of the surgical patient, assuring maximum operative convenience with built-in **Image Amplification** compatibility.

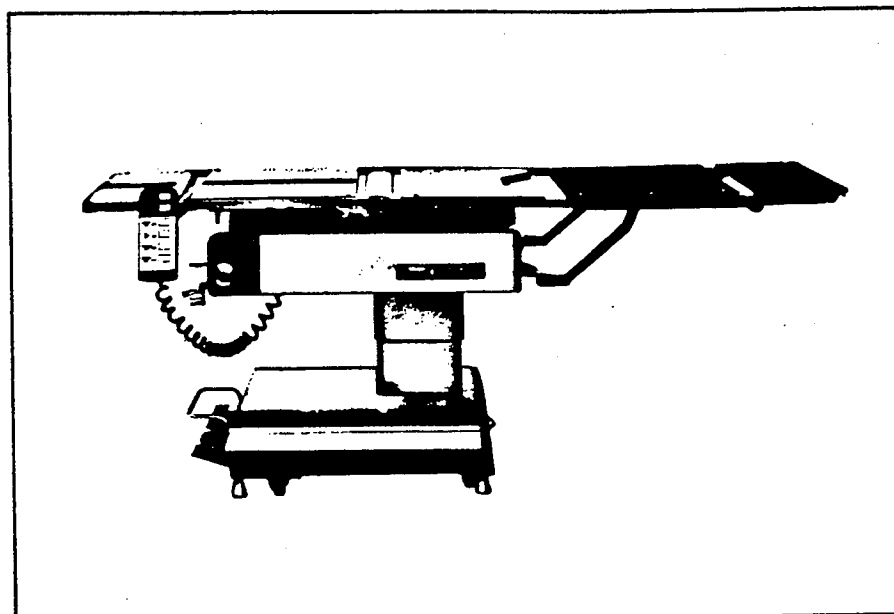
DESIGN AND CONSTRUCTION

**General.** The 2080RC I.A. table complies with the *Radiation Control for Health and Safety Act* of October 18, 1968. Electro-hydraulically operated for easy positioning. Table offers, in addition to its lever-operated control system, "Touch Command" ... for precise positioning of the table from outside the surgical field.

**Base** is cast iron with textured-enamel finish. The top is enclosed by a welded, stainless-steel cover that also forms a shroud for the lower portion of the pedestal. A swivel caster and height-adjustable floor lock at each corner of the base are actuated by a single pedal. Both are electrically conductive, conforming with applicable requirements of NFPA's publication *Flammable Anesthetics Code*. The base provides comfortable toe space on both sides as well as space to freely insert a flat-blade Mayo stand. A NFPA-approved patient grounding receptacle is provided at foot-end of base.

**Hydraulic System** is also contained within the base assembly. The electro-hydraulic pump and motor assembly forms a straight-line sealed unit; the motor includes overload protection. An auxiliary pump provides manual

<p><b>2080 SERIES</b> <b>Major Surgical Tables</b></p> <p>• remote control • I.A. compatible</p>	<p><b>TECH</b> <b>DATA</b></p>
--	------------------------------------



Typical only — some details may vary.

operation in event of electrical power failure, without sacrificing table-positioning flexibility.

**Pedestal** includes tabletop lift cylinder, support column with bearing-mounted saddle frame, hydraulic piping, and electrical wiring. These are fully enclosed by stainless-steel telescoping shrouds. Each shroud is one-piece construction to ensure against foreign matter entering the elevating mechanism.

THE SELECTION CHECKED BELOW  
APPLIES TO THIS EQUIPMENT

Option:

☐ Accessories (see separate product literature)

Item No. \_\_\_\_\_

Location(s) \_\_\_\_\_

\_\_\_\_\_

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**Superstructure** includes gears, motors and other devices required to position and articulate the tabletop. The frame is cast aluminum finished with textured-enamel paint. The superstructure is bearing-mounted to the elevating mechanism and power-assisted to handle heavy loads with ease. Indicators show degree of lateral tilt and Trendelenburg.

Positioning mechanism is fully enclosed by stainless-steel covers to prevent entanglement of drapes. Power-assisted movements are quick, smooth and precise. There's built-in safety to prevent accidental movement.

**Tabletop.** The 20-inch (508-mm) wide tabletop (see page 4) is divided into five hinged sections: head, back, seat, leg and head/foot. Head, back and seat sections are cast aluminum (back and seat sections are covered by stainless-steel veneer, while leg and head/foot sections are constructed of radiotranslucent material in imaging areas). Drilled holes are included for the radiographic top. Stainless-steel side rails, notched to receive optional accessories, extend the full length including the superior edge of head rest. Mounting hardware and a full complement of optional accessories are available ... see separate product literature.

The leg and back sections are safely supported by two hinged, steel lever arms.

The tabletop is bearing-mounted to the superstructure at the seat section. The seat section includes a perineal cutout. The tabletop (with exception of the head and head/foot sections) is electro-hydraulically positioned by gear-actuated lever linkage. The head section is secured by a manual, spring-loaded, ratchet mechanism. A Velcro® (Velcro Corporation) tape strip on the longitudinal centerline of the table permits instant application and removal of 1" (25 mm) thick mattress pads ... no other pad-fastening devices are required.

An independently operated kidney elevator is centrally located between the back and seat sections. The elevator is raised and lowered by a crank and dual rack and pinion mechanism, operating in conjunction with the gearing and jointed drive shaft. The kidney elevator is cast aluminum covered by stainless-steel veneer.

The head/foot section, attached to leg section, extends table length to permit reversing the patient on the table for Image Amplification. The head/foot section can be raised/lowered, 0-90 degrees from horizontal and locked in 15 degree increments. Head/foot section also folds completely under leg section so as not to interfere with standard table positioning. The handle is located at end of section for easy actuation.

**Radiographic Top** is constructed of permeable phenolic and is electrically conductive. It mounts on full width and length of tabletop. The radiographic top complies with the *Radiation Control for Health and Safety Act* of October 18, 1968. A 14x17 inch (356x432mm) radiographic cassette can be inserted from head- or foot-end; 12x14 inch (305x356mm) radiographic cassette, from side, head-end or foot-end. (Radiographic cassettes are not furnished by AMSCO.)

## OPERATING CONTROLS

Control actuators and selectors requiring operator attention are at the head-end of the table, easily accessible to the anesthesiologist.

**Foot Pedals** feature low-profile design ... do not obstruct the surgeons' approach. They include:

- **LOCK** — to engage either the casters or locks with the floor.
- **LOWER** — to lower the tabletop.
- **RAISE** — to raise the tabletop.
- **POWER** — to (1) energize the hydraulic pump, (2) serve as a safety device to avoid accidental movement of the tabletop, and (3) allow manual pumping of the hydraulic system should electric power fail.

**Tabletop Positioning Controls** are mounted at a convenient height on the superstructure ... arranged for simple, accurate actuation. After setting the selector for the desired movement, the tabletop is positioned by operating the POWER pedal and control actuator. Actuators return to neutral upon release. Selections include:

- **TRENDELENBURG** — to lower or raise the head-end of the superstructure from horizontal, to achieve Trendelenburg (head down) and reverse Trendelen-

burg (head up). Control is on left side of head end.

- **BACK** — to lower or raise the back section.
- **SIDE** — to laterally tilt the superstructure to the right or left.
- **LEG** — to lower or raise the leg section.
- **FLEX** — to simultaneously position the back and seat sections so as to achieve an inverted "V" (flex) or "V" (reflex) position.

## REMOTE CONTROL

The Remote Control Unit is handheld ... outside of the surgical field. It controls the raising, lowering and positioning of the tabletop electro-hydraulically as previously described. The control is connected to the table by a coiled rubber cord approximately 4 feet (1219mm) long. The control is lightweight and, when not in use, clips anywhere along table side and head rails. Six clearly indicated rocker switches are double-acting and self-neutralizing ... this means easy, fingertip operation. Unmistakable power push buttons must be energized simultaneously with selector switch, thus providing dual safety control. A power indicating light signals when table is energized.

## ACCESSORIES

*See separate product literature.*

## MATERIAL SPECIFICATIONS

**General.** Materials not definitely specified herein are of the best quality routinely employed for the purpose in the industry. They have been selected to enhance the safety, serviceability and appearance of the finished product.

**Finish.** Exposed stainless steel (conforming with ASTM Specification A 167), aluminum and chromium-plated surfaces are polished. Cast iron and carbon-steel exterior surfaces are degreased, phosphatized and coated with corrosion-resistant primer followed by two spray coats of textured-enamel paint. The finish is then oven baked.

## PERFORMANCE CAPABILITIES

When operated with a 300-pound (136-kg) load distributed as follows: 25 lbs (11.4 kg) on head section, 100 lbs (45.4 kg) on back section, 140 lbs (63.6 kg) on seat section and 35 lbs (15.9 kg) on foot section; the table shall be positioned as follows without perceptible binding or jerking, and without settling after the positions are obtained. If patient weight exceeds 300 pounds, contact your AMSCO representative for further direction.

Table Component	Position Starting With Superstructure Horizontal	Range
Top and Superstructure	Raise — Lower	To any point within 27 to 45 inches (686 to 1143mm) above the floor.
	Trendelenburg (head down)	0 to 20°
	Reverse Trendelenburg (head up)	0 to 20°
	Tilt to Right	0 to 10°
	Tilt to Left	0 to 10°
Head Section	Raise (from horizontal)	0 to 90°
	Lower (from horizontal)	0 to 90°
Back Section	Raise	0 to 90°
	Lower	0 to 10°
	*Flex	0 to 15°
	*Reflex	0 to 10°
Seat Section	*Flex	0 to 20°
	*Reflex	0 to 15°
Leg Section	Lower (with Seat Section horizontal)	0 to 105°
Head/Foot Section	Raise (with seat section horizontal)	0 to 90°
	Lower (with seat section horizontal)	0 to 180°
Kidney Elevator	Raise (from tabletop level)	approx. 4½ inches (114mm)

\*Flex and Reflex positioning involves simultaneous movement of Back, Seat and Foot sections.



# CHAPTER I OPERATION

## 1. OPERATING INSTRUCTIONS 2080L AND 2080 COMPAT IV

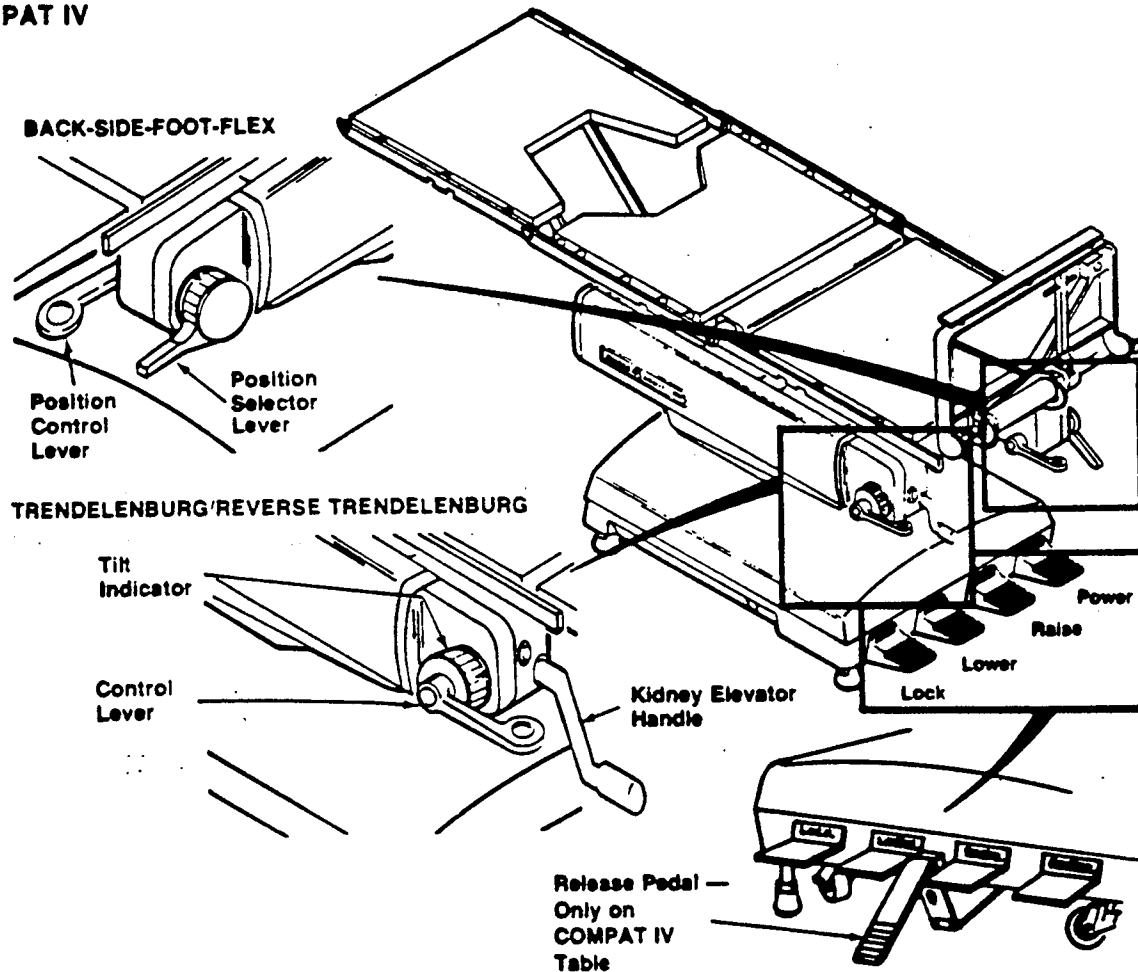


Figure 1-1. 2080L AND 2080 COMPAT IV CONTROLS.

### a. Attaching 2080 COMPAT to Fixed Pivot

Depress release pedal. Align table base with pivot and slowly push table onto pivot. When table is properly positioned, release pedal will remain up. Table is automatically mated with power and grounding contacts.

### b. Power Control

All controls are conveniently located at the table head end. Two simple control levers provide complete maneuverability of the tabletop. On the right side is the BACK-SIDE-FOOT-FLEX control ... on the left, the TRENDLENBURG/REVERSE TRENDLENBURG control. Both control levers are within easy reach of the anesthesiologist. Clearly identified foot pedals allow the

table to be RAISED or LOWERED throughout an 18" range ... smoothly and quietly.

#### (1) Back-Side-Foot-Flex Control

(a) Move Selector Lever to BACK, SIDE, FOOT or FLEX.

(b) Move Control Lever to actuate table section selected. (Direction that lever is moved will govern direction of tabletop movement.)

(c) Depress and hold POWER pedal.

(d) Release of Control Lever or POWER pedal automatically stops the tabletop and locks it in position.



**NOTE:** Dual safety control is purposely designed to eliminate accidental movement of tabletop during surgery.

(2) Trendelenburg/Reverse Trendelenburg Control

(a) Lower Control Lever for Trendelenburg positioning ... raise for Reverse Trendelenburg positioning.

(b) Depress and hold POWER pedal.

(c) Release of Control Lever or POWER pedal automatically stops the tabletop and locks it in position.

**NOTE:** An easy-to-read Tilt Indicator shows the degree of angulation.

(3) Raise-Lower Control

(a) Depress RAISE pedal to elevate tabletop ... depress LOWER pedal to lower tabletop.

(b) Release of RAISE or LOWER pedal automatically stops tabletop and locks it in position.

**c. Emergency Power Failure Positioning**

Emergency operation is the same as POWER CONTROL except:

(1) Position the tabletop as follows:

(a) Select the tabletop section to be positioned.

(b) Actuate the Control Lever.

(c) Pump the POWER pedal.

(2) To elevate the tabletop, pump the RAISE pedal.

---

**CAUTION: FORCING THE POWER PEDAL DURING EMERGENCY OPERATION WITHOUT FIRST POSITIONING ONE OF THE CONTROL LEVERS EXERTS UNDUE STRAIN ON THE POWER PEDAL SHAFT AND MECHANISM. THIS SHOULD BE AVOIDED.**

---

**d. Head Section and Kidney Elevator Controls**

These controls must be manually operated. The head section has a ratchet-type Position-control Lock which is located beneath the head section. The Kidney Elevator Handle is located adjacent to the Trendelenburg Control Lever.

(1) Head Section

(a) Pull the Release Handle (spring loaded) towards the table head end.

(b) Place the head section in the desired position.

(c) Release the Handle to lock the head section in position.

(2) Kidney Elevator (Units Shipped Before 8/74)

(a) Turn the Selector on the handle ratchet clockwise to raise the kidney elevator ... counterclockwise to lower.

(b) Raise and lower the Handle in a jacking motion until the desired height of the kidney elevator is obtained.

(3) Kidney Elevator (Units Shipped After 8/74)

(a) Rotate handcrank clockwise to raise kidney elevator.

(b) Rotate handcrank counterclockwise to lower kidney elevator.

**e. Pads and Accessories**

The conductive rubber mattress pads are backed with Velcro<sup>®</sup> strips which fasten to opposing strips on the tabletop. Removable accessories are positioned and secured by clamps or sockets which are applied to (and slide along) the side rails.

(1) Pads

(a) To install, place pad in position and press Velcro strips together.

(b) To remove, "peel" pad away from tabletop.

## (2) Accessories

(a) To install, place clamp (or socket) on the side rail and lock in position with the knob (or handle) provided.

(b) To remove the clamp (or socket) from the side rail, loosen the knob (or handle) and slide clamp (or socket) along rail until a notch is reached ... remove clamp. **NOTE:** Clamp (or socket) may also be removed from the end of side rail by lowering the stop.

## 2. OPERATING INSTRUCTIONS 2080RC AND 2080RC I.A.

**WARNING — DO NOT USE THIS TABLE IN PRESENCE OF FLAMMABLE GASES.**

**NOTE: 2080RC I.A. TABLE SHOWN.**

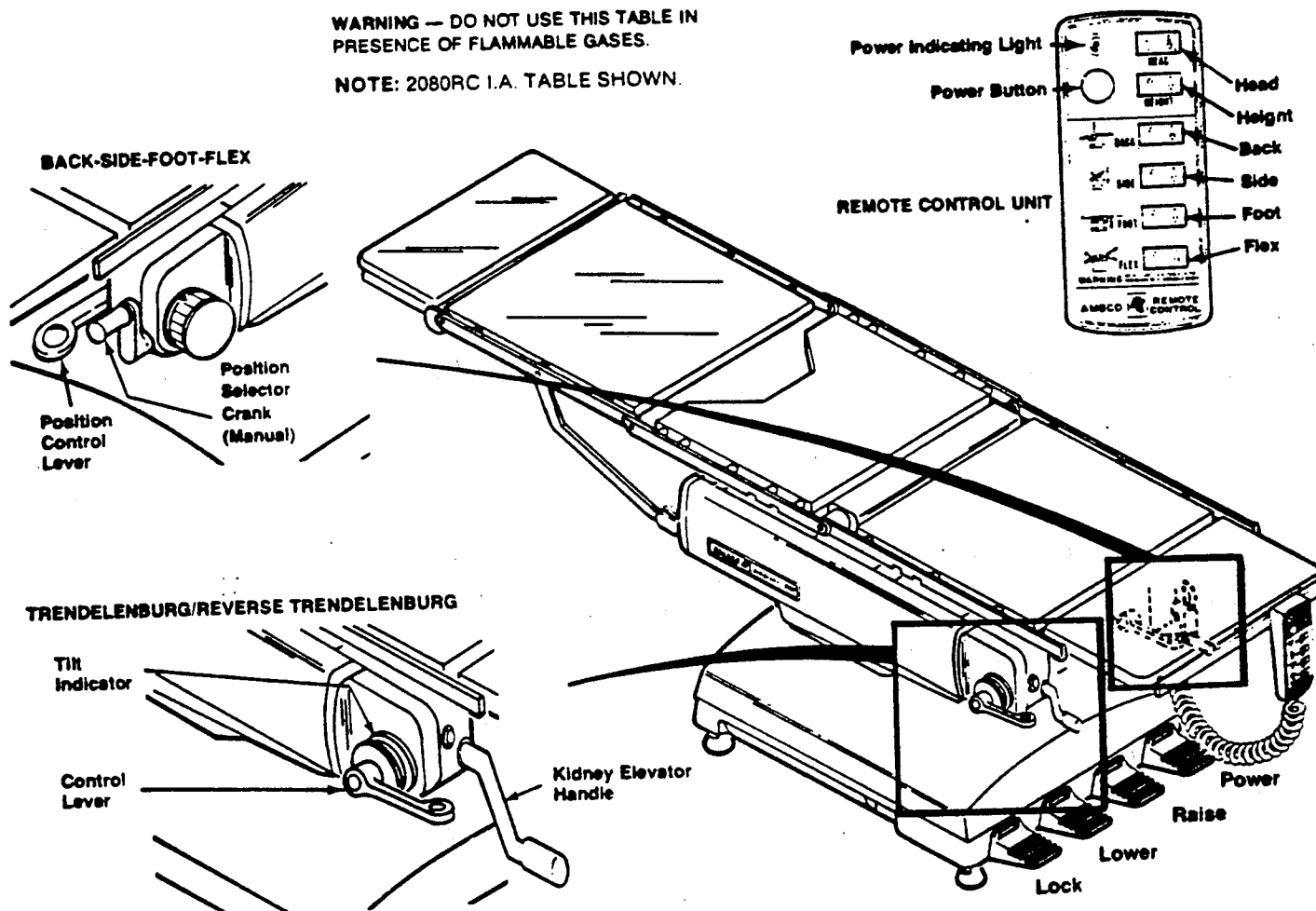


Figure 1-2. 2080RC AND 2080RC I.A. CONTROLS.

### a. Power Control

**WARNING: TIPPING HAZARD. DO NOT OPERATE THIS TABLE WITHOUT ENGAGING FLOOR LOCKS.**

Power control is provided through a remote control unit at a point outside of the surgical field. (The remote control unit attaches to the table when not in use.) Secondary controls, at the head end of the table, may be used if required.

### (1) Remote Control Unit

HEAD (Trendelenburg/Reverse Trendelenburg), HEIGHT (Raise-Lower), BACK, SIDE, FOOT, and FLEX switches automatically provide the desired type and direction (as indicated on each switch) of tabletop movement. A pilot light indicates when the remote control unit is energized.

**(2) Head Down (Trendelenburg) -- Head Up (Reverse Trendelenburg) Control**

(a) Push and hold HEAD switch. (Direction that switch is pushed will govern direction of tabletop movement.)

(b) Push and hold POWER button.

(c) Release of HEAD switch or POWER button automatically stops the tabletop and locks it in position.

**NOTE:** An easy-to-read Tilt Indicator (on the table) shows the degree of angulation.

**(3) Raise-Lower Control**

(a) Push and hold HEIGHT switch. (Direction that switch is pushed will govern direction of tabletop movement.)

(b) Push and hold POWER button.

(c) Release of HEIGHT switch or POWER button automatically stops tabletop and locks it in position.

**(4) Back-Side-Foot-Flex Control**

(a) Push and hold the BACK, SIDE, FOOT or FLEX switch. (Direction that switch is pushed will govern direction of tabletop movement.)

(b) Push and hold POWER button.

(c) Release of Position switch or POWER button automatically stops the tabletop and locks it in position.

**NOTE:** Dual safety control is purposely designed to eliminate accidental movement of tabletop during surgery.

**(5) Secondary Controls**

Two simple control levers provide complete maneuverability of the tabletop. On the left side is the TRENDELENBURG/REVERSE TRENDELENBURG control ... on the right, the BACK-SIDE-FOOT-FLEX control. Both control levers are within easy reach of the

anesthesiologist. Clearly identified foot pedals allow the table to be RAISED or LOWERED throughout an 18" range ... smoothly and quietly.

**(6) Trendelenburg/Reverse Trendelenburg Control**

(a) Lower Control Lever for Trendelenburg positioning ... raise for Reverse Trendelenburg positioning.

(b) Depress and hold POWER pedal.

(c) Release of Control Lever or POWER pedal automatically stops the tabletop and locks it in position.

**NOTE:** An easy-to-read Tilt Indicator shows the degree of angulation.

**(7) Raise-Lower Controls**

(a) Depress RAISE pedal to elevate tabletop ... depress LOWER pedal to lower tabletop.

(b) Release of RAISE or LOWER pedal automatically stops tabletop and locks it in position.

**(8) Back-Side-Foot-Flex Control**

(a) Push in and turn Selector Crank for the BACK, SIDE, FOOT or FLEX position.

(b) Move Control Lever to actuate table section selected. (Direction that lever is moved will govern direction of tabletop movement.)

(c) Depress and hold POWER pedal.

(d) Release of Control Lever or POWER pedal automatically stops the tabletop and locks it in position.

**NOTE:** Dual safety control is purposely designed to eliminate accidental movement of tabletop during surgery.

**b. Emergency Power Failure Positioning**

Emergency operation is the same as POWER CONTROL (on the table) except:

(1) Position the tabletop as follows:

- (a) Select the tabletop section to be positioned.
- (b) Actuate the Control Lever on the table.
- (c) Pump the POWER pedal.

(2) To elevate the tabletop, pump the RAISE pedal.

**CAUTION: FORCING THE POWER PEDAL DURING EMERGENCY OPERATION WITHOUT FIRST POSITIONING ONE OF THE CONTROL LEVERS EXERTS UNDUE STRAIN ON THE POWER PEDAL SHAFT AND MECHANISM. THIS SHOULD BE AVOIDED.**

#### c. Head Section and Kidney Elevator Controls

These controls must be manually operated. The head section has a ratchet-type Position-control Lock which is located beneath the head section. The Kidney Elevator Handle is located adjacent to the Trendelenburg Control Lever.

##### (1) Head Section

(a) Pull the Release Handle (spring loaded) towards the table head end.

(b) Place the head section in the desired position.

(c) Release the Handle to lock the head section in position.

##### (2) Kidney Elevator (Units Shipped Before 8/74)

(a) Turn the Selector on the handle ratchet clockwise to raise the kidney elevator ... counterclockwise to lower.

(b) Raise and lower the Handle in a jacking motion until the desired height of the kidney elevator is obtained.

##### (3) Kidney Elevator (Units Shipped After 8/74)

(a) Rotate handcrank clockwise to raise kidney elevator.

(b) Rotate handcrank counterclockwise to lower kidney elevator.

#### d. Head/Foot Section (2080RC I.A.) Control

**WARNING: CRUSHING HAZARD. CAUTIOUSLY LOWER LEG SECTION OR POSITION TABLE IN REVERSE TRENDLENBURG WHEN HEAD/FOOT SECTION IS EXTENDED.**

The head/foot section has a ratchet-type lock. The release or control handle (located beneath the working surface on the right side of the table) is spring loaded to assure positive locking action. To adjust, pull the release handle away from the leg section. Head/foot section can be raised/lowered, 0-90 degrees from horizontal and lock in 15 degree increments. Section also folds completely under leg section so as not to interfere with standard table positioning.

#### e. Pads And Accessories

The conductive rubber mattress pads are backed with Velcro® strips which fasten to opposing strips on the tabletop. Removable accessories are positioned and secured by clamps or sockets which are applied to (and slide along) the side rails.

##### (1) Pads

(a) To install, place pad in position and press Velcro strips together.

(b) To remove, "peel" pad away from tabletop.

##### (2) Accessories

(a) To install, place clamp (or socket) on the side rail and lock in position with the knob (or handle) provided.

(b) To remove the clamp (or socket) from the side rail, loosen the knob (or handle) and slide clamp (or socket) along rail until a notch is reached ... remove clamp. NOTE: Clamp (or socket) may also be removed from the end of side rail by lowering the stop.

**NOTE:** The feet should not turn freely by hand; the adjustment should require a wrench. Feet that turn freely will not hold adjustment; therefore, the leg assembly 77728 should be replaced.

(2) Place LOCK pedal in its down (locked) position. Adjust all four feet counterclockwise until they are snug (slight resistance is noticed) on the floor.

(3) Place LOCK pedal in its up position. Adjust all four feet counterclockwise  $\frac{1}{2}$  turn.

(4) Operate the LOCK pedal through several cycles. Operation should be smooth and positive; the table base should rise evenly as the floor lock is actuated (not one side before the other). With the lock engaged, the table should not rock or move when normal forces are applied. You may find that a further  $\frac{1}{4}$ -turn of the feet in either direction will "fine tune" the operation.

**b. Binding of Pedal Linkage** (see WARNING on page 2-1). If binding is evident during pedal operation, place LOCK pedal in its unlocked position and check the following.

(1) Lift and support the base cover as described in paragraph 1a of this chapter.

(2) Press down on top of floor lock rods 41530 and then release, allowing the lever arms to spring back. If this action is not free, proceed as follows:

(a) Be sure the reamed holes in the base casting for the floor lock feet are properly lubricated.

(b) Be sure pivot holes in lever arms are free to rotate on the shoulder screws 82481. (NOTE: Excessive plating in a hole could result in a tight fit and subsequent binding.)

(c) Check for interference between any two parts which would require an increased effort to operate (e.g., ends of lever arms riding on the base casting during operation).

(3) Depress LOCK pedal slightly (but not enough to lock) and then release. Repeat this several times. Be sure the pedal does not rub on the base casting, drip pan or other surfaces. The pedal should spring back rapidly when released; if it does not, proceed as follows:

(a) With the tabletop at its maximum height, lean the table against the wall and block the base to prevent it from moving.

(b) Remove the two screws 31838 in each of the three bearing blocks 78203; then take out the floor lock cross shaft 55084. If necessary, remove a caster 36584 by unfastening the nut 13397 on the top of the base casting.

(c) Measure the free length of the pedal return spring 80117. Replace spring if it is not  $2\frac{1}{4} \pm 1/16$  inches long.

(d) Check the hole in the underside of the base casting from which the pedal return spring was removed. Be sure the camber ( $\frac{1}{4}$  inch by 45 degrees) is sufficient to prevent the spring from catching.

(e) Replace the cross shaft, pedal return spring and bearing blocks removed in step b. Operate the cross shaft several times to be sure there is no binding. If necessary, loosen the screws and reposition the bearing blocks. (NOTE: The shaft will bind if the bearing blocks are not in line.)

(f) Check the adjustment of the pedal return spring set screw 80196 on the top of the base casting, accessible through the hole in the motor support. The screw should be adjusted to extend approximately 7/16 inch above the base casting. Turn the screw clockwise to increase spring tension and aid pedal return.

(g) Inspect the two cams 77731 on the ends of the cross shaft. Replace them if the cam surfaces are not smooth. Be sure the cams are parallel and contact the lever arm rollers 45272 simultaneously. The roller can be repositioned by moving the supports for the locking arms.

**c. Insufficient Clearance Between Pedal and Floor** (see WARNING on page 2-1)

Proceed as follows if the pedal is striking or coming too close to the floor during floor lock operation.

(1) Lift and support the base cover as described in paragraph 1a of this chapter.

(2) Loosen the four screws 31838 which secure the bearing blocks 77521 supporting the latch casting 55088.

(3) Place an equal number of shims under both bearing blocks at each screw.

(4) Operate the floor locks and observe the latch operation. Be sure the pin 79878 in the pedal arm engages the latch during locking and that the latch swings clear of the pin during unlocking. If necessary, increase the height of the latch spring 47777 on the base stud 47939 by repositioning the two nuts 3097. The distance between the bottom nut and the base casting should be approximately 1-5/16 inches. The floor locks are designed to operate on a relatively level floor. If table is used in a room with a slope to a floor drain, further adjustments may be necessary.

**d. Pedal Sticks In Up Position (see WARNING on page 2-1)**

Proceed as follows if the pedal will not depress.

(1) Lift and support the base cover as described in paragraph 1a of this chapter.

(2) Be sure the pin 79878 is centered in the pedal arm and that it is locked in place with the set screw 10585.

(3) Be sure latch 55088 operates properly.

(4) Refer to step 4 in paragraph 2c of this chapter and check the adjustment of the latch spring.

**e. Pedal Does Not Return To Maximum Up Position (see WARNING on page 2-1)**

If the pedal does not return to the maximum up position, the pedal arm pin will not properly engage the latch during the next lock cycle. Therefore, proceed as follows:

(1) Lift and support the base cover as described in paragraph 1a of this chapter.

(2) Be sure the pedal leveling screws 79593 (Fig. 8-37, sheet 2) are properly adjusted, and the LOCK pedal screw does not prevent it from returning to the maximum up position.

(3) Refer to step 4 in paragraph 2c of this chapter and check the latch operation.

(4) Refer to step 3 in paragraph 2b of this chapter and check the condition and adjustment of the pedal return spring.

### 3. HYDRAULIC SYSTEM

**a. Oil Level (See WARNING on page 2-1)**

(1) Remove base cover and support as outlined in paragraph 1a of this chapter. Tabletop must be at maximum height.

(2) Remove pipe plug 20580 (Fig. 8-27, sheet 1 [RC] or Fig. 8-28, sheet 1 [L]) which is located in the left-hand rear corner of the base assembly.

(3) Insert a clean, dry object about the size of a pencil through the hole now vacated by the set screw until object touches bottom of the sump.

(4) Withdraw object and measure indicated height of the oil. Depth of oil should be 1 3/4 inches. If oil level is below this height, add the proper oil. (See NOTE below.) Do not overfill.

**NOTE:** This table uses Chevron AW32 oil. Substitute oil should not be used.

(5) Replace plug and base covers.

**b. Strainer.** A dirty or plugged strainer can result in erratic, sluggish or noisy table operation. To clean the strainer, proceed as follows:

See **WARNING** on page 2-1.

(1) Lift the base cover and support as described in paragraph 1a of this chapter.

(2) Disconnect hydraulic fitting from strainer 42542-091 (Fig. 8-30.)

(3) Unscrew strainer 42542-091 from manifold 78198-091 and back flush the strainer to clean.

### c. Hydraulic Leakage.

There should be no signs of oil leakage from any part of the superstructure or base. Leakage can be caused by loose fitting on copper pressure hydraulic lines, defective leather cups on the lift cylinder, defective O-rings, defective gabriel valves, Vickers valve, selector motors or the pump assembly. If leakage is observed other than fittings, remove defective element and replace if necessary.

When checking the lift cylinder for an oil leak that causes the tabletop to lower, do not overlook the possibility that the leak may be from the cylinder bleeder port. This port is in the small assembly piston rod 758077 (Fig. 8-34, 8-35 or 8-36) and is revealed only when the lift cylinder is fully extended. If oil is leaking past the O-ring seal, it will run down the piston rod inside the upper cylinder cap 80932 with all indications of a leaking cup seal. Oil leakage at the bleeder port is mainly caused by an overtightened screw which tends to extrude or distort the O-ring seal. This screw should be tightened only enough to seal the bleeder port. Check the bleeder port for oil leakage as follows:

- (1) Elevate the tabletop to maximum height.
- (2) Wipe the piston rod dry in the area of the bleeder port.
- (3) Wait five minutes, then rub the piston rod below the bleeder port with your finger to see if bleeder port is leaking oil.
- (4) If oil is leaking, replace O-ring and screw.

## 4. TABLE ELEVATION

Depress RAISE pedal to raise the table to its maximum height. The table should rise smoothly and quietly. Depress the LOWER pedal. Table should lower smoothly and quietly to the lowest position.

## 5. TABLETOP POSITIONING

By correctly manipulating the positioning controls (described in Chapter I, Operation, it should be possible to articulate the tabletop to any position within its specified limits. The action of the position selector lever (2080L) or position selector crank (2080RC)

should be easy and positive. The action of the positioning mechanism should be positive and smooth. If tabletop positioning adjustments are required, proceed as follows:

**NOTE:** The back section 55105 and leg section 55104 both have a lever arm assembly 55114 which requires adjustment. The procedure described below is applicable to both back and leg section.

**a. Back or Leg Section Adjustment.** The back and leg section both have a worm and gear which may require adjustment. If adjustment is required, proceed as follows: (Refer to Fig. 8-3 or 8-3A, sheet 1 [RC] or Fig. 8-4 or 8-4A, sheet 1 [L].)

- (1) Loosen two large nuts 16212 on lever arm assembly 55114-1 (back adjustment) or 55114-2 (leg adjustment).
- (2) Tighten stop nut 80930 on the trendelenburg side of tabletop. Thrust washer 16201 (Fig. 8-12 or 8-13) must not be free to finger rotation.
- (3) Rotate eccentrics 16197 on both sides of tabletop until contact is made between worm and gear 16247. Eccentrics should be adjusted to same relative position.
- (4) Rotate shaft 16218 (Fig. 8-12 or 8-13) in each direction a few times.
- (5) Rotate eccentrics 16197 on both sides of tabletop an equal amount to obtain minimum clearance between worm and gear.
- (6) Turn eccentric 16197 on the drive side counter-clockwise slightly (approximately  $\frac{1}{8}$  turn) until worm and gear are free moving by hand rotation.
- (7) Lock the drive side eccentric in place with large nut 16212.
- (8) Position eccentric 16197 on the trendelenburg side to same relative position as the eccentric on drive side.
- (9) Lock trendelenburg side eccentric in place with large nut 16212. Free movement of worm and gear must be possible at this point.

**b. Seat Section Adjustment.** The seat-section has a worm and sector which may require adjustment. If adjustment is required, proceed as follows: (Refer to Fig. 8-3 or 8-3A, sheet 1 [RC] or Fig. 8-4 or 8-4A, sheet 1 [L].)

- (1) Remove plug buttons 26577 by prying free.
- (2) Loosen cap screws 3902 on both sides of tabletop.

(3) Centralize sector on worm 16290 (Fig. 8-8) by turning eccentric 16235 on drive side clockwise while, at the same time, moving the seat section laterally back and forth.

(4) Rotate drive side eccentric 16235 to obtain minimum clearance between worm and sector. Force eccentric snugly against section support and secure cap screw 3902.

(5) Rotate trendelenburg side eccentric 16235 to the same relative position as the drive side eccentric. Force eccentric snugly against section support and secure cap screw 3902.

**NOTE:** Free movement of worm and sector 16290 (Fig. 8-8) should be possible at this point. Readjust slightly if necessary to achieve free movement.

- (6) Replace plugs 26577.

**c. Trendelenburg Adjustment.** The trendelenburg section has a worm and sector which may require adjustment. End play and stop limit adjustments may also be required on the trendelenburg section. If adjustment is required, proceed as follows: (Refer to Fig. 8-3 or 8-3A, sheet 2 [RC] or Fig. 8-4 or 8-4A, sheet 2 [L].)

- (1) Worm and Sector Adjustment.

- (a) Back off nut 24987 which secures swivel head screw 80193.
- (b) Loosen swivel head screw 80193.
- (c) Loosen cap screws 80222.
- (d) Loosen nut 3099 and cap screw 5895.

(3) Align worm vertically into sector of shaft and bearing assembly 133676-001 using swivel head screw 80193 to achieve minimum clearance but free movement.

(f) Tighten three cap screws 80222 to secure shaft and bearing assembly 133676-002 to side frame.

(g) Tighten cap screw 5895 and lock with nut 3099.

- (2) End Play Adjustment. (Refer to Fig. 8-16).

(a) Loosen set screw 4772 in nut 16189.

(b) Tighten adjusting nut 16189 until worm 77639 cannot be rotated by hand.

(c) Back off adjusting nut slowly until rotation of worm is possible.

(d) Lock adjusting nut 16189 with set screw 4772.

(3) Stop Limits Adjustment (Refer to Fig. 8-3 or 8-3A, sheet 2 [RC] or Fig. 8-4 or 8-4A, sheet 2 [L]).

(a) Position tabletop to 18° trendelenburg.

(b) Position stop 77682 against lever 80288 and secure.

(c) Position tabletop to 18° reverse trendelenburg.

(d) Position stop 77682 against lever 80200 and secure.

**d. Drive Head Adjustment.** The drive head assemblies of the leg section, seat section, and back section may require adjustment to remove all possible end play of related parts while maintaining free movement of gear involved.

**NOTE:** Check each section adjustment with distributed weight of approximately 300 pounds on tabletop. Weight distribution: Head Section 25 pounds; Back Section 100 pounds; Seat Section 140 pounds; Leg Section 35 pounds. (Refer to Fig. 8-21 [RC] or 8-22 [L].)



**(1) Leg Section**

(a) Loosen cap screw 16425 as required to allow turning of adjusting nut 16184 in leg section.

(b) Back off adjusting nut 16184 so that bearing 16209 is tight and not capable of hand rotation while positioning leg section from horizontal to down position, whereas thrust washer 16214 is free to rotate by hand. Reposition leg section from down to horizontal will reverse this condition, i.e., thrust washer 16214 will be tight and bearing 16209 is free to rotate by hand.

(c) After adjustment is complete, tighten cap screw 16425 to lock adjusting nut 16184.

**(2) Seat Section (Refer to Fig. 8-21 [RC] or 8-22 [L]).**

(a) Loosen cap screw 16425 as required to allow turning of adjusting nut 16184 in seat section.

(b) Back off adjusting nut 16184 so that bearing 16249 is tight and not capable of hand rotation while positioning seat section from horizontal to flex position, whereas thrust washer 16214 is free to rotate by hand. Repositioning seat section from flex to horizontal will reverse this condition, i.e., thrust washer 16214 will be tight and bearing 16249 is free to rotate by hand.

(c) After adjustment is complete, tighten cap screw 16425 to lock adjusting nut 16184.

**(3) Back Section (Refer to Fig. 8-21 [RC] or 8-22 [L]).**

(a) Loosen cap screw 16425 as required to allow turning of adjusting nut 16115 in back section.

(b) Back off adjusting nut 16115 so that thrust washer 16201 is tight and not capable of hand rotation while positioning back section from horizontal to back up position, whereas bearing 16204 is free to rotate by hand. Repositioning back section from back up to horizontal will reverse this condition; i.e., bearing 16204 will be tight and thrust washer 16201 is free to rotate by hand.

(c) After adjustment is complete, tighten cap screw 16425 to lock adjusting nut 16115.

**6. LIFT CARRIAGE ADJUSTMENT (Refer to Fig. 8-33)**

**a. Cam and Roller Adjustment.** The elevation guide assembly on table support assembly 133636 has eight bearings 46572 that regulate the amount of table-top movement which can be measured at the head or foot end of the table. If adjustments are required to reduce the amount of "play" or movement, proceed as follows:

See **WARNING** on page 2-1.

(1) Lift and support the base cover described in paragraph 1a of this chapter.

**NOTE:** Always adjust the eccentrics on one side of the square pedestal only, as this greatly simplifies the adjustment. However, check the four eccentrics on the opposite side to make sure that they are all set in the same relative position and turned in by the same amount.

**NOTE:** Eccentrics 46478 have a locating mark on the low side of the eccentric. When adjusting eccentrics, it is important that the locating mark on each eccentric be in the same relative position.

(2) Back off on hex nuts 78314 which secure set screws 80116.

(3) Loosen set screws 80116 as required to allow bearing slides 77528 to hang free. The slides will not be tightened until after eccentric adjustment is complete.

(4) Loosen four small set screws 43223 that lock eccentrics 46478.

(5) Back off on four nuts 78314 that seat against the eccentric faces on the side you want to adjust.

(6) Set bearing pressure against column by rotating eccentrics 46478, two in line at the same time, for required adjustment. In the majority of cases, this adjustment will be very small. Adjust the top two eccentrics first, then repeat for the bottom two eccentrics. The locating mark on all four eccentrics should be in the same relative position.

(7) Check bearing adjustment by sliding the support assembly up and down the entire length of the column. Make sure that all eight bearings make contact with the column through entire length of column. Readjust eccentrics if necessary.

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**CAUTION: Nuts 78314 should be tightened only with slight wrench pressure. Excessive tightening will fracture eccentric at flange.**

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(8) After adjustment is complete, tighten set screws 43223 and then lock eccentrics with nuts 78314. Make sure eccentric setting is not disturbed.

**b. Slide Bearing Adjustment.** (Refer to Fig. 8-27, sheet 1 [RC] or Fig. 8-28, sheet 1 [L].) The elevation guide assembly on table support assembly 133636 has two bronze slide bearings 77528 that regulate the tabletop movement from side to side. If adjustments are required to reduce the amount of "play" or movement, proceed as follows:

(1) Support the tabletop so that slide bearings 77528 are approximately one-half way up the column.

(2) Centralize the carriage assembly laterally about the column by adjusting eight set screws on the sides of the carriage.

**NOTE:** Adjust set screws 80116 (Fig. 8-33) on both sides in equal amounts when bringing bearing faces against column to insure parallel adjustment.

(3) Tighten set screws 80116 (Fig. 8-33) against slide bearings 77528 so as to form a seat in the bearing surface, then back off on the screws slightly.

(4) Adjust set screws 80116 so that the slide bearings are snug against the square column, eliminating all possible slide movement of tabletop but still allowing free movement of carriage along the full length of the column.

(5) Lock set screws 80116 in place with nuts 78314 (figure 8-31).

(6) To check adjustment of the slide bearings, try to rock the tabletop from side to side. If necessary, readjust.

## 7. SIDE TILT ADJUSTMENT (Refer to Fig. 8-23)

**a. End Play Adjustment.** Maximum allowable movement of tabletop at side rail edge is 1/16 inch with the top in horizontal position. If adjustment is required, proceed as follows:

(1) Position table top to side tilt, left side (from head end) of table down and in trendelenburg. to expose adjusting nuts 75819. Position should be one turnback from maximum.

**NOTE:** Set screws 10583 and nylon plugs 80203 secure adjusting nuts 75819.

(2) Loosen two set screws 10583 and move two adjusting nuts 75819 away from each other.

(3) Turn the front adjusting nut 75819 against thrust bearings 75828 (Fig. 8-3 or 8-3A, sheet 3 [RC] or Fig. 8-4 or 8-4A, sheet 3 [L]) to eliminate all end play. Moving of tabletop from side to side while adjusting is recommended.

(4) Secure the rear adjusting nut 75819 against the front adjusting nut and lock by tightening set screw 10583.

**b. Nut, Power Screw Lateral Play.** The following adjustment should remove all lateral play yet permit free rotation of nut.

(1) To reduce excessive movement of Power Screw 78247 (Fig. 8-23) in nut 83250, tighten two screws 13102 against plate 80108 until screw bottoms. At this point the power screw will drag or bind. Back screws out slightly in equal amounts to relieve drag but take up thread clearance which was producing side movement.

(2) Tighten button head screws 80213 (Fig. 8-1) to secure end plates 80111 on one side of the table support assembly.

(3) For units shipped prior to 2/82 — tighten screws (13102) until (by trial and error) power screw begins to drag. Back out two screws 1/4-turn.

**c. Yoke and Saddle Clearance Adjustment.** Tighten hex nut 80115 (Fig. 8-1) until side tilt movement becomes difficult. Back off 1/4 turn on nuts.

## 8. FOUR-WAY (GABRIEL) VALVE ADJUSTMENT

Check that the distance between top and bottom of valve lever 78199 (Fig. 8-14 [RC] or 8-15 [L]) and gabriel valve 42563 is equal and is approximately 9/32 inch. If one dimension is less than the other, adjust set screw 42629 in valve lever 78199 counterclockwise, 1/4 turn at a time, until the dimensions are equal.

**NOTE:** If valve lever 78199 is loose after adjustment, turn both adjusting set screws (42629) clockwise 1/4 turn at a time until all lateral play is removed from valve lever and both dimensions are equal.

## 9. PEDAL LEVELING — RAISE/LOWER ACTUATORS AND SOLENOIDS

### a. Pedal Adjustment

See **WARNING** on page 2-1.

(1) Raise and support base cover as described in paragraph 1a of this chapter.

(2) Adjust set screws 15343 (Fig. 8-37, sheet 2) so that there is approximately 1/8 inch from the edge of pedals to top of front plate.

### b. Raise/Lower Lever Actuator Adjustment

See **WARNING** on page 2-1.

(1) Raise and support base cover as described in paragraph 1a of this chapter.

(2) Loosen two cap screws 48060 (Fig. 8-37, sheet 2) that hold raise actuator lever assembly 78232.

(3) Move lever assembly up or down as necessary so that lever has 1/4 inch movement when pedal is completely depressed.

(4) Tighten cap screws 48060 and repeat steps (1) through (3) above for the lower actuator lever assembly (78231).

### c. Raise/Lower Solenoid Adjustment

See **WARNING** on page 2-1.

(1) Raise and support base cover as described in paragraph 1a of this chapter. (4-way valve should be adjusted per preceding paragraph.)

(2) Loosen three cap screws 15339 (Fig. 8-27, sheet 2) that secure solenoid assembly mounting plate 55274.

(3) Slide solenoid assembly mounting plate forward or back so that solenoid will have 1/16 inch more travel when pedal is depressed.

(4) Tighten cap screws 15339.

### d. Hydraulic System Raise/Lower Valve Dynamic Adjustment

See **WARNING** on page 2-1.

(1) Raise and support base cover as described in paragraph 1a of this chapter.

(2) Refer to Figs. 2-2, 8-30 and 8-37, sheet 2.

(3) Place a 3/8" diameter screw or equivalent spacer between valve 55278 and valve lever 78199 as shown in Fig. 2-2.

(4) Apply pressure on rod "A" (Fig. 2-2) to prevent spacer from dropping out.

(5) Keeping pressure on rod "A", insert Allen wrench in adjusting screw "L" and slowly turn clockwise until tabletop starts to lower; then turn wrench counterclockwise 1/4 turn.

(6) With pressure still applied to rod "A", insert Allen wrench in adjusting screw "R" and depress **POWER** pedal with your right knee. Slowly turn wrench clockwise until tabletop starts to rise; then turn wrench counterclockwise 1/4 turn.

(7) Release pressure on rod "A" and remove spacer. Lower base cover.

(8) Operate the **RAISE** and **LOWER** pedals to be sure table is functioning; then test adjustment of raise/lower valve as follows:

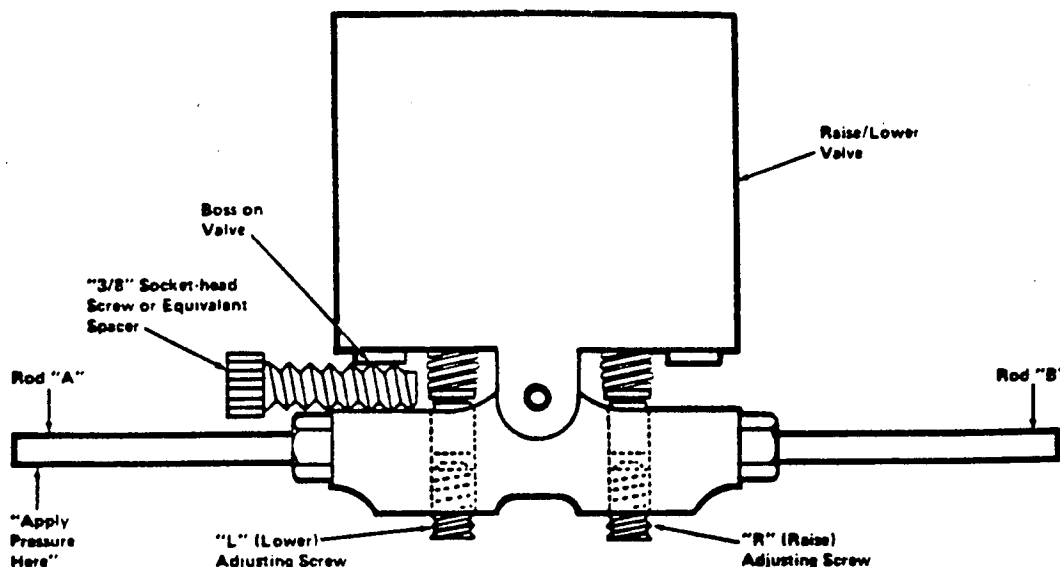


Figure 2-2. RAISE/LOWER VALVE (TOP VIEW).

**NOTE:** Unless set for zero leakage, the raise/lower valve should permit pressure in the hydraulic system to escape when force is applied to the tabletop.

relieve static pressure is included in the pressure line. Should the pedal action become tight, the valve 42605 located in the left-hand rear corner of the base assembly may be adjusted as follows:

(a) Lower tabletop foot section.

(b) Stand on right side of table (as viewed from end of table having pedals). Depress POWER pedal with your left foot; grasp tabletop foot section with your right hand; and actuate position control lever (to raise foot section) with your left hand.

(c) As foot section starts to rise, attempt to hold back on it with your right hand. If you are unable to do so (approximately 50 to 75 pounds pressure), raise/lower valve is properly adjusted. If you are able to prevent foot section from rising, lift base cover and turn adjusting screw "L" counterclockwise  $\frac{1}{4}$  turn, repeat the above test.

(9) After achieving correct setting, secure base cover.

## 10. ADJUSTMENT OF RAISE AND POWER PEDALS

Static pressure in the hydraulic system is a common cause of RAISE and POWER pedals becoming difficult to operate. A flow-control valve 42605 (Fig. 8-30) to

See **WARNING** on page 2-1.

a. Raise and support base cover as described in paragraph 1a of this chapter.

b. Loosen hex locknut of flow-control valve 42605 and turn adjustment stem clockwise to close; **do not** overtighten.

c. Turn stem counterclockwise  $\frac{1}{4}$  turn (hold stem with pliers to prevent it from turning), then tighten locknut.

d. Remove tabletop support and lower base cover.

e. Operate the RAISE and POWER pedals. Repeat above procedure if pedals are still difficult to operate; however, turn stem counterclockwise  $\frac{3}{4}$  in lieu of  $\frac{1}{4}$  turn.

**CAUTION:** Do not open valve more than  $\frac{1}{2}$  turn as it may cause loss of pressure in the hydraulic system. If this procedure does not correct the problem, replace the valve 42605.

f. After satisfactory setting has been achieved, tighten locknut (while holding stem) on flow-control valve 42605 and secure base cover.

## 11. MOTOR ACTUATOR CONTROL CABLE AND SOLENOID ADJUSTMENT

### a. Cable Adjustment

See **WARNING** on page 2-1.

(1) Raise and support base cover as described in paragraph 1a of this chapter.

(2) Depress the POWER pedal to determine if motor switches on before pedal is fully depressed. If not, release set screw 10585 in actuator 78238 (Fig. 8-27, sheet 1) and move inner cable wire. If motor is switching on before POWER pedal is fully depressed, pull wire into actuator slightly; if motor doesn't switch on with lever fully depressed, move wire in opposite direction.

### b. Motor Solenoid Adjustment

**NOTE:** With solenoid in retracted position, motor switch should be on. If not, perform the following adjustment.

See **WARNING** on page 2-1.

(1) Raise and support base cover as described in paragraph 1a of this chapter.

(2) Loosen four mounting screws on solenoid 77717 (Fig. 8-27, sheet 1).

(3) Hold motor switch in the on position and slide solenoid assembly so that plunger will be bottomed.

(4) Tighten screws on solenoid 77717.

## 12. FRICTION DEVICE ON LIFT CYLINDER-ADJUSTMENT (Units Shipped before 12/72)

This unit controls the staging of the elevating cylinders as the table moves through its "Raise-Lower" operating range. Being a friction device, it requires readjustment from time to time and should be checked once every three months (see **WARNING** on page 2-1).

**NOTE:** The following procedure requires Test Fixture P-753909-091 and Spring Scale, 0 to 50 pound range, P-757290-091 (both available from Regional Office).

a. Lift and support the base cover as described in paragraph 1a of this chapter.

b. Depress the "Lower" pedal and place a weight on it to prevent it from rising. Manually compress the lift cylinder 133634-001 (Fig. 8-34) to its minimum height.

c. Remove lift cylinder from base assembly by removing four screws 13796 (Fig. 8-27, sheet 1) and disconnecting fitting 52737 (Fig. 8-34) from cylinder base and fitting 47101 from collector can 55369-001.

d. Assemble test fixture to top of  $\frac{3}{4}$ " diameter piston rod on lift cylinder. Connect spring scale to test fixture.

e. With lift cylinder at minimum height, gradually pull up on spring scale until small piston breaks free; note the scale reading. (This piston should break free at less than 15 pounds; if it won't, cylinder must be replaced.)

f. With the small piston fully extended, continue pulling up on the spring scale until the larger cylinder breaks free; note the scale reading.

g. The friction device split ring 81142-001 must be adjusted so that the larger cylinder (Step f) will break free at a force 8 to 10 pounds higher than that for the smaller cylinder (Step e). If necessary to adjust the friction device, turn the two screws 48486 clockwise to increase friction, counterclockwise to decrease friction.

h. Repeat Steps e and f three times after the proper friction setting is obtained. If the same differential is not present during each check, replace the lift cylinder and again repeat Steps e and f three times to confirm that break points are within the limits.

i. Remove the spring scale and test fixture. Replace cylinder in table base. Pressurize cylinder and check for leaks at fittings.

j. Remove the weight from the "Lower" pedal. Raise the tabletop to its maximum height and remove the spacer (wrench). Lower and secure the base cover.

k. Raise the tabletop to its maximum height. Measure the exact distance from the floor. After one hour, again measure the table height. If it has decreased more than  $\frac{1}{16}$ ", check for leaks; correct and retest, as necessary.

### 13. SELECTOR ASSEMBLY SWITCH ADJUSTMENT

The following procedure describes how to make a bench check adjustment of selector assembly 99428. An ohmmeter or buzzer circuit can be used to check switch contact closure. (Refer to Figs. 2-3 and 8-24.)

a. With cam 77649 in the position indicated in Fig. 2-3, check that switch 1 is made just before nose of cam is under centerline of roller.

b. Raise or lower switch if necessary using adjusting nuts on switch. Roller face must be parallel to cam movement.

c. Operate selector cam manually through positions 2, 3 and 4, checking to see that each switch is made just before nose of cam is under centerline of roller. Readjust if necessary.

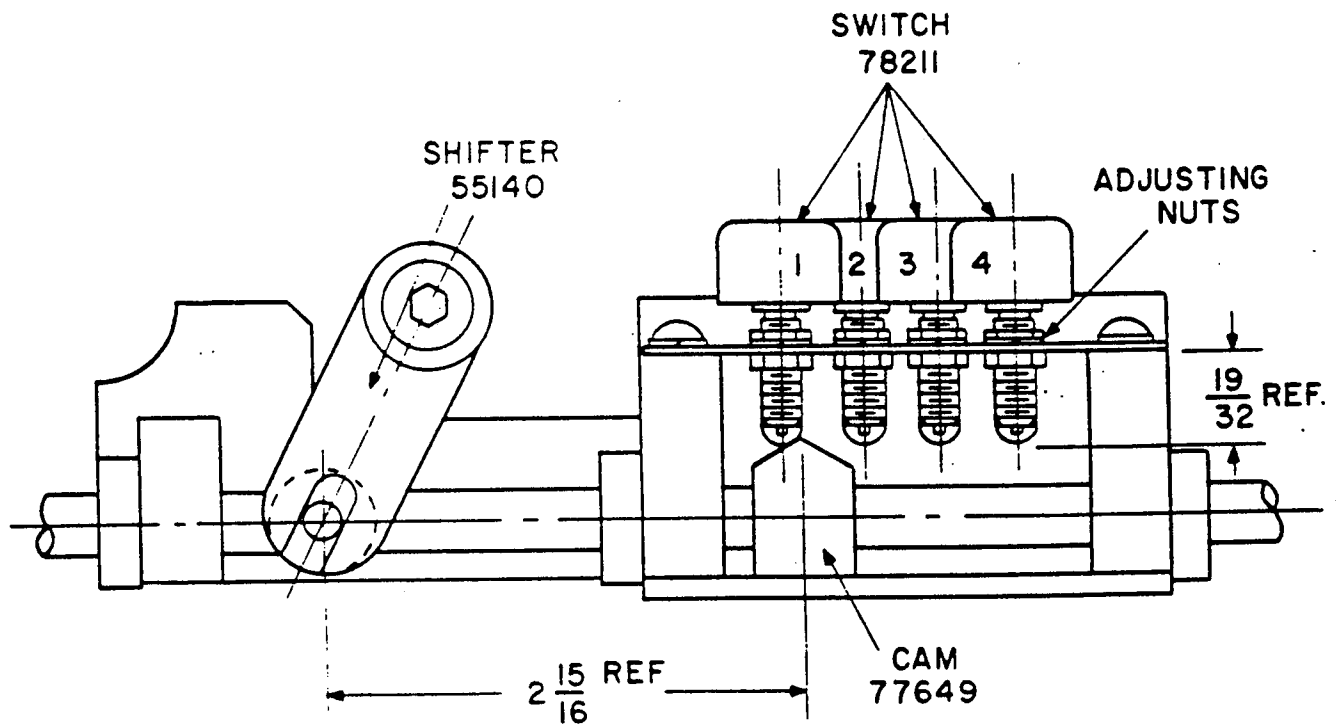


Figure 2-3. SELECTOR ASSEMBLY SWITCH ADJUSTMENT.

#### 14. ELECTRICAL CONTACT CLEANING — 2080 COMPAT

**WARNING: DISCONNECT POWER AT WALL  
BOX PRIOR TO INSPECTING AND CLEANING  
CONTACTS.**

- a. Depress release pedal and pull table away from pivot.

- b. Inspect contacts on table and pivot (Figs. 8-41 and 8-43) for signs of corrosion, deterioration due to arcing, or foreign matter accumulation.

- c. If necessary, clean contacts with "Caeon #27" (Caig Laboratories, Inc., Escondido, California) or other non-flammable solvent and burnish with fine emory cloth. For minor deterioration, burnishing with emory cloth should be sufficient.

#### 15. ELECTRICAL INTEGRITY

- a. Verify unit complies with National Electric Code current leakage; 500  $\mu$ Amps (General Patient) or 100  $\mu$ Amps (Critical Care).

- b. Ensure ground resistance is less than 0.1 ohm.

## 16. PREVENTIVE MAINTENANCE GUIDE

EQUIPMENT: 2080L/2080RC/2080RC I.A./2080 COMPAT IV Surgical Tables

*This form is to be used as a preventive maintenance record and as a guide to performing preventive maintenance. The frequency indicated is the minimum and should be increased if usage of the unit demands.*

(Circle "X" In Bi-Monthly Column When Service Is Performed)

PROCEDURES	Inspections					
	1	2	3	4	5	6
<b>1.0 PREPARATION FOR PREVENTIVE MAINTENANCE</b>						
1.1 Discuss equipment operation with department personnel.	X	X	X	X	X	X
1.2 Remove pads. Examine pad covers and velcro (pads and table) tape.	X	X	X	X	X	X
1.3 Examine clamps and other side rail hardware.	X	X	X	X	X	X
1.4 Tighten side rails.	X	X	X	X	X	X
1.5 Unfasten and lift table covers.	X	X	X	X	X	X
<b>2.0 HYDRAULIC SYSTEM</b>						
2.1 Clean oil strainer.			X			X
2.2 Replace oil filter element.			X			X
2.3 Check hydraulic oil level.	X	X	X	X	X	X
2.4 Inspect floor directly beneath the table and all tubing, fittings and components of hydraulic system for oil leaks.	X	X	X	X	X	X
<b>3.0 CASTERS AND FLOOR LOCKS</b>						
3.1 Clean and inspect casters.	X	X	X	X	X	X
3.2 Lubricate casters.		X			X	
3.3 Check floor lock mechanism for proper operation.	X	X	X	X	X	X
<b>4.0 SELECTOR ASSEMBLY SWITCH (2080RC only)</b>						
4.1 Using remote control, check table positioning.	X	X	X	X	X	X
<b>5.0 ELECTRICAL CHECKS (if applicable)</b>						
5.1 Disconnect table from facility electrical supply.	X	X	X	X	X	X
5.2 Inspect remote control box (2080RC only).	X	X	X	X	X	X
5.3 Verify unit complies with National Electric Code current leakage 500 $\mu$ Amps (General Patient) or 100 $\mu$ Amps (Critical Care). Ensure ground resistance is less than 0.1 ohm.	X	X	X	X	X	X
5.4 Check all table functions using foot pedals (2080RC).	X	X	X	X	X	X
5.5 Inspect electrical cord.	X	X	X	X	X	X
5.6 Connect table to proper electrical supply.	X	X	X	X	X	X



## 16. PREVENTIVE MAINTENANCE GUIDE (Continued)

PROCEDURES	Inspections					
	1	2	3	4	5	6
<b>6.0 TABLETOP OPERATION</b>						
6.1 Check operation of back section.	X	X	X	X	X	X
6.2 Check operation of foot section with seat section horizontal.	X	X	X	X	X	X
6.3 Check flex then reflex operation.	X	X	X	X	X	X
6.4 Check lateral tilt operation.	X	X	X	X	X	X
6.5 Check Trendelenburg then Reverse Trendelenburg operation.	X	X	X	X	X	X
6.6 Check Kidney Elevator operation.	X	X	X	X	X	X
6.7 Check raise and lower operation.	X	X	X	X	X	X
6.8 Check head section operation.	X	X	X	X	X	X
<b>7.0 MANUAL EMERGENCY PUMP OPERATION</b>						
7.1 Pump raise pedal to check manual table operation.	X	X	X	X	X	X
<b>8.0 DRIVE GEARS</b>						
8.1 Verify proper engagement of clutch keys and drive head gears.	X		X		X	
<b>9.0 FINAL TEST</b>						
9.1 Examine all lubricated parts. Apply lubrication as needed.	X			X		
9.2 Secure all covers.	X	X	X	X	X	X
9.3 Install all pads.	X	X	X	X	X	X
9.4 Police work area to ensure removal of all materials used during inspection.	X	X	X	X	X	X

## CHAPTER III LUBRICATION

The table below lists gears, worms, gear sectors, and other items which require periodic lubrication. The table provides a reference to the illustration where the part may be located and indicates the time interval at which the part must be lubricated. For ease of location, lubrication points are indicated in the right-hand column of the exploded views in Chapter VIII, adjacent to the applicable part. Refer to the applicable note indicated in the table for applicable lubricant.

### NOTES:

1. Lubricate with Moly-Lubriplate type MS HD No. 2 (ordering specification RM 6400-825, 5 pound can).

2. Lubricate with Lubriplate type 630 AA (ordering specification RM 6400-140, 5 pound can).

3. Apply a light coat of a good grade of medium-weight lubricating oil to the inner diameter of sleeve bearings, the faces of thrust bearings, shafts, and other moving parts when replacing a part.

4. Coat the sides of the square column on which the rollers do not roll with Moly-Lubriplate. Do not lubricate sides of the column on which the rollers roll.

5. Lubricate the reamed holes where rods 41530 come up through base casting with Moly-Lubriplate.

6. Lubricate linkages 77725 or 92524 and 77727 or 82479 where they interlock with rods 41530. Lubricate with Moly-Lubriplate.

### LUBRICATION

ITEM	INTERVAL	FIG. REF.	SEE NOTE
Spur Gear 15220 (RC)	6 Mo.	8-3 or 8-3A (1)	2
Shaft 76253 (RC)	6 Mo.	8-3 or 8-3A (1)	2
Worm Gear 16247 (RC)	6 Mo.	8-3 or 8-3A (1)	2
Bearing 16285 (RC)	6 Mo.	8-3 or 8-3A (1)	2
Gear 15220 (L)	6 Mo.	8-4 or 8-4A (1)	2
Shaft 76253 (L)	6 Mo.	8-4 or 8-4A (1)	2
Gear 16247 (L)	6 Mo.	8-4 or 8-4A (1)	2
Bearing 16285 (L)	6 Mo.	8-4 or 8-4A (1)	2
Worm Sector 16290	3 Mo.	8-8	1
Gear 42727 (RC)	6 Mo.	8-10	2
Gear 42727 (L)	6 Mo.	8-11	2
Gear 16108	3 Mo.	8-12	1
Gear 16106	3 Mo.	8-13	1
Bearings (16182) (80190)	3 Mo.	8-16	1
Inner Races 80189 and 80191	3 Mo.	8-16	1
Shaft 80188	3 Mo.	8-16	1
Worm Gear 77639	3 Mo.	8-16	1
Universal Joint 76543	6 Mo.	8-16	2
Ratchet 78220	6 Mo.	8-18	2
Handle Pin 82604	6 Mo.	8-18A	2
Shaft 77668	6 Mo.	8-19	2
Shaft 82606	6 Mo.	8-19A	2

## LUBRICATION (Continued)

ITEM	INTERVAL	FIG. REF.	SEE NOTE
Shaft 82605	6 Mo.	8-19A	2
Washer 16952	6 Mo.	8-19A	2
Worm Gear 16234	6 Mo.	8-20	2
U/Joint 20200	6 Mo.	8-20	2
Bearing 44766	3 Mo.	8-20	1
Shaft 16227	6 Mo.	8-20	2
Coupling 77552	6 Mo.	8-20	2
Bearings 16271	3 Mo.	8-21, 8-22	1
Bearings 16233	3 Mo.	8-21, 8-22	1
Bearings 16213	3 Mo.	8-21, 8-22	1
Bearing Blocks 43323	3 Mo.	8-21, 8-22	1
Bearing Blocks 43213	3 Mo.	8-21, 8-22	1
Bearing Blocks 43217	3 Mo.	8-21, 8-22	1
Shaft 43267	3 Mo.	8-21, 8-22	1
Gears 16105	3 Mo.	8-21, 8-22	1
Gears 22728	3 Mo.	8-21, 8-22	1
Gears 16107	3 Mo.	8-21, 8-22	1
Gears 16109	3 Mo.	8-21, 8-22	1
Drive Heads 28047	3 Mo.	8-21, 8-22	1
Drive Heads 28046	3 Mo.	8-21, 8-22	1
Drive Heads 28049	3 Mo.	8-21, 8-22	1
Drive Heads 28048	3 Mo.	8-21, 8-22	1
U/Joint 78246 or 92128	6 Mo.	8-23	2
Power Screws 78247	6 Mo.	8-23	2
Bearing 80112	3 Mo.	8-23	1
Gear 78219	6 Mo.	8-24	2
Gear 78218	6 Mo.	8-24	2
Bearings 77528	6 Mo.	8-27 (1)	2
Bearings 77528	6 Mo.	8-28 (1)	2
Shafts 77527	6 Mo.	8-33	2
Bearings 46572	6 Mo.	8-33	2
Shafts 77720, 77594 and 133686	3 Mo.	8-37	1
Guides 77725 or 92524	3 Mo.	8-40 (1)	6
Bars 77727 or 82479	3 Mo.	8-40 (1)	6
Rods 41530	3 Mo.	8-40 (1)	5
Shaft 77524	3 Mo.	8-40 (2)	1
Castors 36584	6 Mo.	8-40 (2)	2
Pin 77519	3 Mo.	8-40 (2)	1

## CHAPTER IV HYDRAULIC SYSTEMS

### 1. GENERAL DESCRIPTION

Figure 4-1 is the hydraulic schematic diagram for the 2080L and 2080RC tables. The drive-side Vickers valve and drive-side shift motor in the top right-section of the schematic are unique to the 2080RC and 2080RC I.A. tables, the rest of the diagram is common. To determine the function of any circuit element, refer to the associated Block Text diagram, Fig. 4-2.

### 2. FILLING

Check oil level as described in paragraph 3a of Chapter II. If oil is required add oil using hose and funnel. System requires approximately 3 quarts. Chevron AW32 is the only recommended oil. When filled, the sump has a measurable oil level of 1½ inches with table at maximum height. Do not overfill.

### 3. BLEEDING

(1) Lift the base cover and support as described in paragraph 1a of Chapter II (see **WARNING** on page 2-1).

(2) With the table at its maximum height, slip a thick object such as a hammer handle between lift carriage 133636 (Fig. 8-28, sheet 1) and elevator stop 52682. Slip the object in from the front.

**NOTE:** While bleeding, it is important that the bleeding port, which is located on the upper rod of the lift cylinder, does not drift down below the top of the intermediate cylinder.

(3) Back out Buttonhead set screw and put pressure on the Raise pedal. When oil starts to flow out through set screw, the majority of air is out of the system. At this time, tighten screw.

### 4. REPLACING HYDRAULIC OIL

**CAUTION:** Do not mix different brands of oil.  
**Recommended oil — Chevron AW32.**

(1) Drain all oil from table sump, tubing and lift cylinder. Discard oil.

(2) Wipe out sump.

(3) Change oil filter assembly (refer to chapter 7, figures 7-3 and 7-4).

(4) Refill the hydraulic system using the recommended oil.

(5) Operate the table through all positions at least once.

(6) Drain sump, tubing and lift cylinder. Discard oil.

(7) Refill hydraulic system, again using the recommended oil.

(8) Operate table through all positions.

(9) Mark tag with type of oil now being used. Attach tag to table base.

**NOTE:** Tables shipped from factory starting with serial number 0406281-XXX will have a tag attached to table base. The tag will identify the type of oil used when table was built. See tag below:

#### THIS EQUIPMENT WAS ORIGINALLY FILLED WITH

- ☐ CHEVRON AW HYDRAULIC OIL GRADE 32
- ☐ MOBIL DTE 24 HYDRAULIC OIL
- ☐ SHELL TELLUS 32 HYDRAULIC OIL

NO SUBSTITUTIONS ARE TO BE USED UNLESS SPECIFIED IN THE OPERATORS MANUAL

AMSCO PT. NO

PT. NO. 54397-013

### 5. TESTING

Testing is required when any hydraulic line is broken or a component has been replaced. Place table in maximum height position and leave in this position for at least 2 hours and preferably 8 hours (or overnight). Measure how much table has dropped during this time. The table should not drop more than 1/16 inch for two hours or 3/8 inch for 8 hours or more. A drop of more than this indicates a hydraulic problem, probably a leaking fitting or a defective valve.

## CHAPTER II

# MAINTENANCE INSPECTION AND ADJUSTMENTS

**WARNING: BE SURE TABLETOP IS PROPERLY SUPPORTED BEFORE PERFORMING ANY MAINTENANCE REQUIRING THE TABLETOP TO BE MAINTAINED IN THE "RAISED" POSITION.**

### 1. SUPPORTING TABLETOP

#### a. With Base Cover Raised (Figure 2-1)

(1) Remove the four socket-head cap screws 52718 (Fig. 8-27, sheet 2 [RC] or Fig. 8-28, sheet 2 [L]) that secure base cover 99324 to the base casting.

(2) Raise the tabletop to its maximum height.

(3) Lift and support base cover 99324 and shrouds 99326 and 99327 by blocking from base or tying to table frame.

(4) Support tabletop by inserting a spacer, ten-inch Crescent wrench or equivalent between the top of 2½-inch-square steel post and underside of the elevator carriage end plates (roller side).

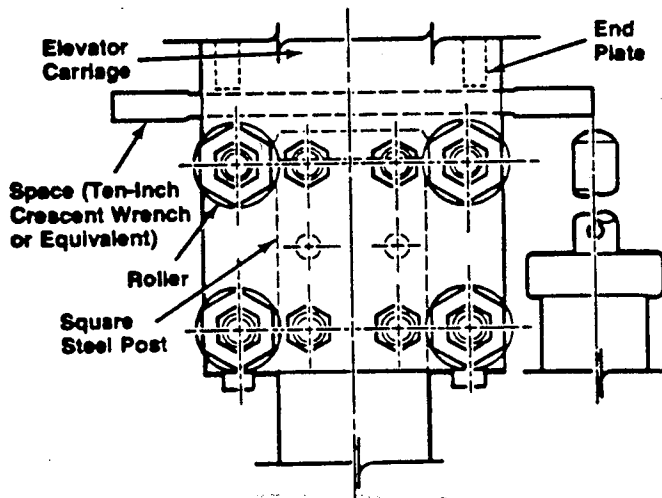


Figure 2-1. SUPPORTING TABLETOP.

(5) Depress LOWER pedal and allow elevator carriage to settle on top of spacer. Release and again depress LOWER pedal to be sure the tabletop is securely supported (cannot lower).

(6) Be sure spacer is not bending. If it is, remove and replace it with a stronger item.

#### b. When Base Cover Is Not Raised

(1) Raise the tabletop to maximum height.

(2) Place a support (saw horse or another table) under the tabletop. Be sure it is so positioned that it will not damage any of the table components.

(3) Depress LOWER pedal to gently lower the tabletop onto the support.

(4) Be sure table is stable.

### 2. FLOOR LOCKS

**NOTE:** Improper adjustment is the main reason for difficult floor lock operation. The force required to operate the floor locks should not change appreciably, whether or not the table is occupied. When the floor locks are properly adjusted, the casters **need not be raised off the floor** (i.e., they should not swing freely with the table in the locked position). Each floor lock should be *equally* engaged and, therefore adjusted individually. Some other reasons for difficult floor lock operation are: binding of pedal linkage, insufficient clearance between pedal and floor, pedal sticking in the up (unlocked) position, or pedal falling to return to the maximum up position.

Be sure you read and understand the entire procedure before attempting to make any adjustments (refer to Fig. 8-40).

Operate the LOCK pedal several times to evaluate floor lock operation, and if necessary, proceed to the applicable problem-correction procedure.

While evaluating floor locks, inspect casters. The conductive compound from which the casters are made fractures easily, particularly when table is moved over irregular surfaces such as thresholds and elevator entrances. If necessary, replace casters. Refer to Chapter 7, Paragraph 9e.

#### a. Floor Lock Improperly Adjusted

(1) Place the LOCK pedal 133687 in its up (unlocked) position. Adjust all four feet 77728 clockwise as far as possible.

TABLE 6-1. TROUBLESHOOTING CHART (PART 2)

POSITION		LOADED EMPTY	LOADED 150 LB.	LOADED 300 LB.
BACK UP		490 P.S.I.	550 P.S.I.	580 P.S.I.
BACK DOWN		420 P.S.I.	450 P.S.I.	480 P.S.I.
LEG UP		510 P.S.I.	545 P.S.I.	560 P.S.I.
LEG DOWN		420 P.S.I.	435 P.S.I.	480 P.S.I.
SIDE — RIGHT		470 P.S.I.	480 P.S.I.	535 P.S.I.
SIDE — LEFT		460 P.S.I.	480 P.S.I.	530 P.S.I.
FLEX		540 P.S.I.	520 P.S.I.	530 P.S.I.
REFLEX		560 P.S.I.	570 P.S.I.	585 P.S.I.
TREND		460 P.S.I.	460 P.S.I.	460 P.S.I.
REV. TREND		470 P.S.I.	470 P.S.I.	475 P.S.I.
RAISE	1-9/16 DIA.	280 P.S.I.	350 P.S.I.	470 P.S.I.
	2 DIA.	180 P.S.I.	230 P.S.I.	275 P.S.I.
LOWER	1-9/16 DIA.	140 P.S.I.	200 P.S.I.	260 P.S.I.
	2 DIA.	90 P.S.I.	140 P.S.I.	180 P.S.I.

Chart shows typical pressures recorded for table positioning with various loads. Pressures shown are average values and with normal operation these pressures will vary  $\pm 40$  P.S.I. except for raise-lower functions.

Gauge location for readings shown for top functions was at bottom of plastic hydraulic coil. Gauge location

for raise-lower functions was located between lift cylinder and raise-lower control valve.

There is approximately 100 P.S.I. drop from bottom to top of hydraulic coil on pressure line and 90 P.S.I. from top to bottom on return side of coil.

## CHAPTER VII

### COMPONENT REPLACEMENT

NOTE: This chapter provides procedures for removing assemblies and detail parts from the table. Reassembly is essentially the reverse of disassembly and may be accomplished by referring to the exploded view illustrations included in Chapter VIII. After replacing a part, perform the appropriate inspection and maintenance procedures in Chapter IV. Always perform applicable testing after replacing a hydraulic component.

#### 1. REMOVING SUPERSTRUCTURE FROM BASE

- a. Engage floor lock.
- b. Elevate table to maximum height.
- c. Support superstructure with horses or some means on each side of column to allow rolling of base out later.
- d. Lift and support the base cover as described in Chapter II, paragraph 1b. (Refer to figure 8-27, sheet 2). On RC unit disconnect wires from 52690 at base terminal board. Disconnect cable clamp 118155.

Disconnect coiled hydraulic tubing 133690 at base fittings two places. Disconnect cable clamp 80925.

Lower base cover to original position. Remove screws 46123 to allow shrouds 99326 and 99327 to drop onto base cover.

- e. [Refer to figure 8-27, sheet 1 (133636, figure 8-31)]. Remove rollers 46572, spacers

77526, 46485 and shafts 77527, etc., from rear side of table support only, leaving other side intact for easier adjusting upon reassembling. Back off wear plate set screws one side.

- f. Depress lower pedal to allow lift cylinder to descend slightly.

- g. Release floor locks and roll base out from under superstructure.

#### 2. HEAD SECTION

- a. Loosen knobs 77559 (figure 8-3, sheet 1 for 2080RC and figure 8-4, sheet 1 for 2080L).
- b. Pull head section 133688 (figure 8-4, sheet 1) from back section.

#### 3. BACK SECTION

(Refer to figure 8-3, sheet 1 and figure 8-4, sheet 1).

- a. Remove screws 9282 and washers 16438 to disconnect the back section from lever arm assembly 55114-001.
- b. Back off on set screws 25834 which lock pivot pins 44440 in position.
- c. Disconnect back section 55105 at the seat section by removing pivot pins 44440.

- d. To remove back section side rails, refer to figure 8-9.

Service Bulletin Number						
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#### 4. LEG SECTION

(Refer to figure 8-3, sheet 1 and figure 8-4, sheet 1).

a. Remove screws 9282 and washers 16438 to disconnect the leg section from lever arm assembly 55114-002.

b. Back off on set screws 25834 which lock pivot pins 43337 in position.

c. Disconnect leg section 55104 at the seat section by removing pivot pins 43337.

d. To remove leg section side rails, refer to figure 8-7.

#### 5. SEAT SECTION

(Refer to figure 8-3, sheet 1 and figure 8-4, sheet 1.)

a. Disconnect pivot points of leg and back sections as described in paragraphs 3 and 4 of this chapter.

b. Pull off plug button 26577 underneath the seat section from each side.

c. Back off screw 3902

d. Rotate eccentric 16235 as necessary to loosen it and pull out pin 16215 on each side. Seat section will drop free.

e. Tilt seat section 55100 to left free of the superstructure.

f. To remove seat section side rails, refer to figure 8-8.

#### 6. BASE COVER AND SHROUDS

(Refer to figure 8-27, sheet 2 and figure 8-28, sheet 2.)

a. Remove superstructure as described in paragraph 1 of this chapter.

b. Remove shrouds 99326 and 99327 by removing from shroud clip 80220 and lifting from base assembly.

c. Remove cover 99324 by removing four socket head screws 52718 and four speed nuts 44086 that secure cover to the base casting. Lift cover free of base assembly.

#### 7. PUMP ASSEMBLY—MANUAL EMERGENCY

(Refer to figure 8-27, sheet 1 or figure 8-28, sheet 1.)

a. Lift base cover and support per Chapter II, paragraph 1b.

b. Remove snap rings 13320 and pin 77590 and disconnect shaft 43474 from pedal support 99309.

c. Disconnect tubing to pump at next fitting from pump.

d. Remove screws 15339 and washers.

e. Remove pumps and bracket and dismantle push pull cable 78307 and related hardware if necessary.

(Refer to figure 8-29 for dismantling of pump components.)

#### 8. ELEVATING CYLINDER

(Refer to figure 8-27, sheet 1 and figure 8-28, sheet 1.)

a. Depress RAISE pedal to raise table to maximum height.

b. Lift and support the base cover as described in paragraph 1b of Chapter II.

c. With the table at its maximum height, slip a strong metal object (such as an 8- or 10-inch Crescent wrench) between the support assembly 133636 and elevator stop 52692. Slip the object in from the front.

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d. Depress the LOWER pedal to the floor and force cylinder 133634 all the way down to vacate oil out of the cylinder. This will prevent spilling of oil when the line is broken.

e. Break the hydraulic line at fitting at the base of lift cylinder 133634 and also break the hydraulic line to fitting on the return line from the collector can.

f. Remove screws 13796 (figure 8-28, sheet 1) and washers 19680 and remove cylinder.

## 9. FLOOR LOCKS

NOTE: With the exception of replacing foot 77721 (figure 8-36, sheet 1), the disassembly procedures described in this paragraph require that the base cover be raised and supported (see paragraph 1b of Chapter II). If it is necessary to tilt the table for access to parts on the underside of the base assembly, first remove the superstructure as described in paragraph 1 of this chapter.

a. **Pin and Foot Assembly.** Pin and foot assembly 77728 (figure 8-36, sheet 1) contains a foot (77721) and a rod (41530) which may be replaced. To replace foot 77721, proceed as follows:

(1) Engage floor lock by depressing the LOCK pedal.

(2) Tilt table as necessary to provide access to foot which is to be removed. For instance, if it is desired to replace a foot on the right side of table, tilt table to the left.

To remove rod 41530 (figure 8-36, sheet 1) proceed as follows:

NOTE: The two linkages overlap each other. When removing linkages from base assembly, first remove linkage that overlaps the other. Then remove the second linkage.

(1) Remove screw 12439 (figure 8-36, sheet 1) and pull linkages 77725 and 77727 free of rod 41530.

(2) Tilt the table and pull rod 41530 through the bottom of the base assembly.

## b. Spring 80117

NOTE: Replacement of spring 80117 (figure 8-36, sheet 2) will be required if the LOCK pedal does not return to raised position after pedal is depressed and then released, after adjustments fail.

(1) Remove set screw 80196 (figure 8-36, sheet 2) from the top of base assembly and check to see if spring 80117 can be removed through hole in top of base assembly.

(2) If spring 80117 cannot be removed from the top of the base assembly, lift base with a hoist or tilt table and support.

(3) Remove bearing blocks 78203 (figure 8-36, sheet 2) by removing attaching screws 31838 and washers.

(4) Lower shaft assembly 55084 to provide access to spring 80117.

## c. Pedal

(1) Repeat step (1) through (4) of paragraph 9c of this chapter to lower shaft assembly 55084 (figure 8-36, sheet 2).

(2) Pull bearing blocks 78203 from shaft assembly 55084.

(3) Remove set screw 40006 (figure 8-36, sheet 2) and remove pedal assembly 133633 by sliding from the shaft.

d. **Cam Roller.** Remove cam roller 45272 (figure 8-36, sheet 1) by removing attaching nuts 2945 and washers 43754.

## e. Casters

(1) Tilt table and support.

(2) Remove nut 13397 (figure 8-36, sheet 2) and washer 19681 attaching caster 36584 to the base assembly.

(3) Remove caster by dropping out of the bottom of the base assembly.

## 10. LIFT CARRIAGE ASSEMBLY

a. Remove the superstructure as described in paragraph 1 of this chapter.

b. Refer to figure 8-1, insert E. Remove nut 80115 and shaft 52734.

c. Refer to figure 8-31. Remove 80114. Remove 80133. Carriage is free to be removed.

## 11. SIDE TILT ASSEMBLY

a. Remove superstructure and lift carriage per paragraph 10 above. Refer to figure 8-3, sheet 3.

b. Remove nut, 80915 gears and thrust bearings.

c. Disassemble from side frame.

Further disassembly of this unit can be accomplished by referring to figure 8-23.

## 12. KIDNEY BRIDGE

a. **Ratchet Handle Assembly.** Remove set screw 77561 (figure 8-3, sheet 2 and figure 8-4, sheet 2) and remove ratchet handle assembly 55269 (figure 8-3, sheet 2 and figure 8-4, sheet 2).

b. **Shaft Assembly. Kidney Bridge.**  
Refer to figure 8-3, sheet 2 or figure 8-4, sheet 2.

(1) Remove stainless steel side cover.

(2) Remove 55142-001.

(3) Remove 78224.

(4) Remove painted cover.

(5) Remove pin 41511 at universal.

(6) Remove screw 3986.

(7) Refer to figure 8-20. Loosen bearing nut 16186.

(8) Further disassembly can be per figure 8-20.

Support Assembly 55138 is now exposed for ease of removal.

## c. Gear Box

(1) Remove Kidney Rack Assembly 22266 by backing out two set screws 25834 (figure 8-2, sheet 1) in side rail link 78200. Remove pins 44440 (figure 8-2, sheet 1) and remove one pin from universal joint adjacent to gear box. Lift assembly out of table.

(2) Refer to figure 8-2, sheet 1 and remove parts 78200, 16578, 52715, 52716 and shims. Back out screw 3967 (figure 8-2, sheet 3) and turn 16285 counterclockwise to remove. Slide shaft 76253 through 53328 far enough to expose gear 16247. Remove pin 24700 which secures gear to shaft and gear box may then be removed.

## 13. TRENDELENBURG SHAFT AND BEARING (figure 8-16)

(Refer to figure 8-3, sheet 2 or figure 8-4, sheet 2.)

a. Remove side cover 135242-001.

b. Loosen nut 3099 and remove screw 5895.

c. Loosen swivel head screws 80192 and 80193.

d. Remove 3 screws 80222 and related washers.

e. Remove unit from side frame.

f. See figure 8-16 for component dismantling.

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#### 14. DRIVE SIDE ASSEMBLY

Refer to figure 8-21)

- a. Remove cover 133664-002 (refer to figure 8-3, sheet 3 or figure 8-4, sheet 3).
- b. Remove pins 14394, 3 places to release clutches 16185, 2 each and 1 of 16198.
- c. Remove snap rings 31952 and pin 43230.
- d. Remove end cover 133655-91.
- e. Slide shaft 43267 toward leg section to clear 43235.
- f. Lower worm gears on back and leg sections away from worms (refer to Chapter II, paragraph 4a) by use of eccentrics. Raise worm sector on seat section away from worm. (Refer to Chapter II, paragraph 4b) by use of eccentrics.
- g. Remove fasteners and washers 44747, 44743 and 25832.
- h. Complete drive train assembly may now be removed with shaft intact or individual drive heads, worm and bearing block may be removed if

problem is localized, by removing shaft completely from end.

#### 15. R.C. SELECTOR ASSEMBLY

- a. Remove cover 133664-002 (figure 8-3, sheet 3).
- b. Remove indicator 77662.
- c. Remove cover 133667.
- d. Disconnect tubing 78399 and 80195 at Vickers valve 80540.
- e. Remove 48060 and 19686.
- f. Remove 77658.
- g. Remove 12423 and 17918.
- h. Remove assembly 99428. Disconnect tubing at orbit motor fittings 30718 if necessary for clearance.
- i. Remove screws 9374 to leave limit switch assembly in side frame. To bring assembly out with selector disconnect wiring back at relay box, figure 8-5.

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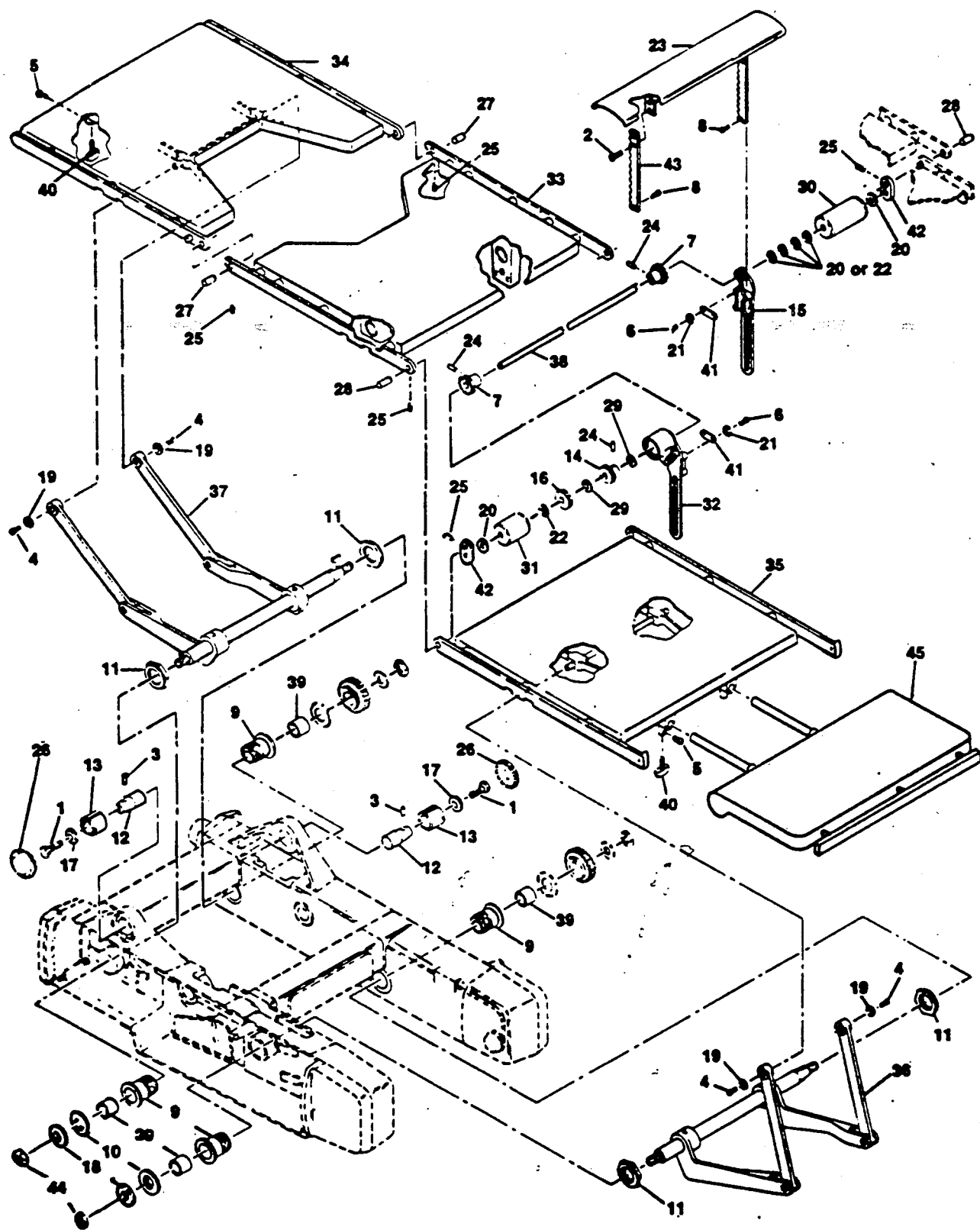


Figure 8-3A. 2080RC TABLETOP ASSEMBLY  
UNITS SHIPPED AFTER 8/74 (Sheet 1 of 3).

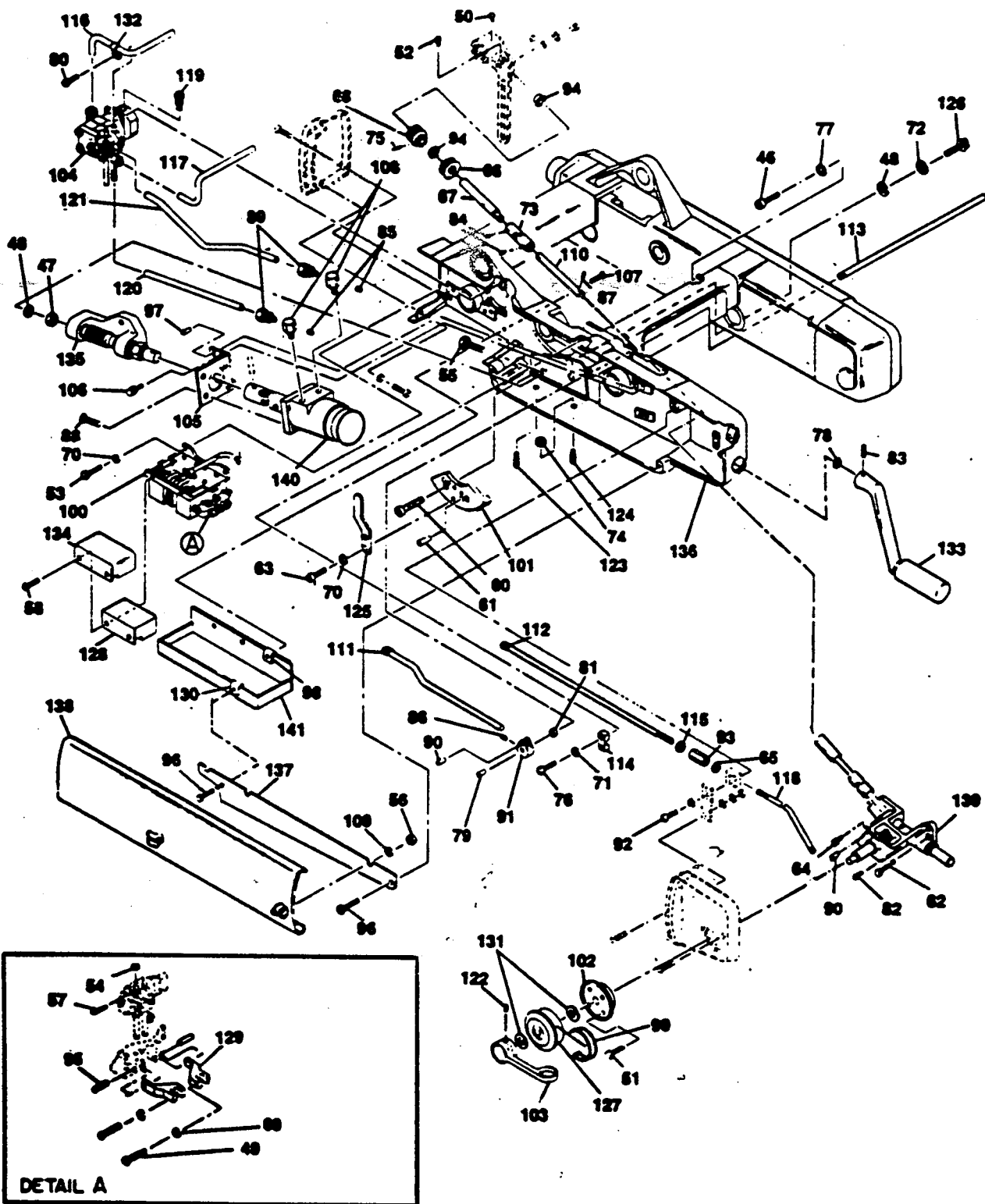


Figure 8-3A. 2080RC TABLETOP ASSEMBLY  
UNITS SHIPPED AFTER 8/74 (Sheet 2 of 3).

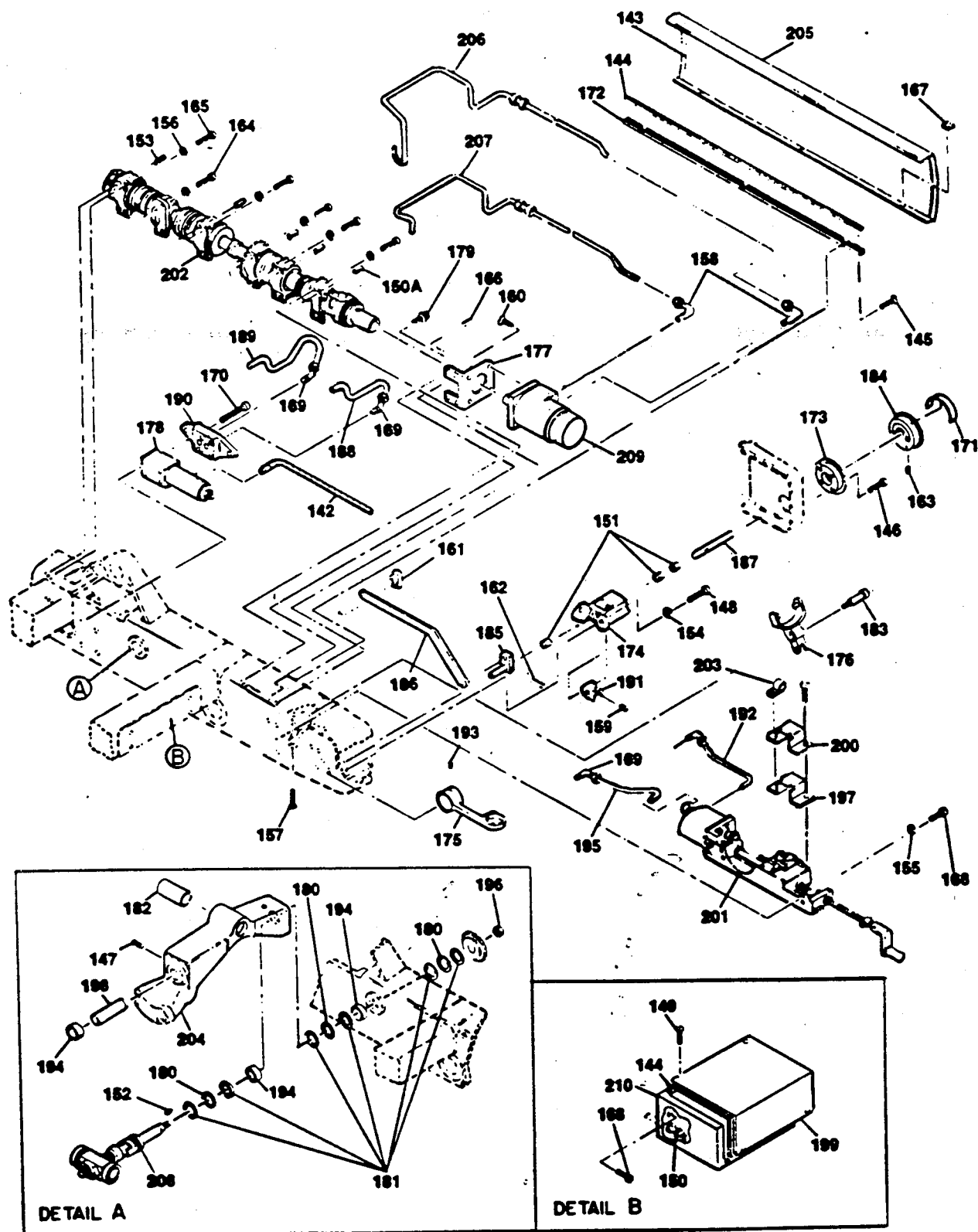


Figure 8-3A. 2080RC TABLETOP ASSEMBLY  
UNITS SHIPPED AFTER 8/74 (Sheet 3 of 3).

†See Parts List.

FIG & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
8-3A	99935-002	RC TABLETOP ASSEMBLY (Units Shipped After 8/74)				
		Sheet 1 of 3				
1	3902-041	SCREW, Hex Head, 3/8-16 x 1	2			
2	3949-042	SCREW, 1/4-20 x 3/4	4			
3	8873-045	PIN, Tube Link	2			
4	9282-041	SCREW, Flat Head, 10-32 x 3/8	4			
5	9645-061	SCREW, Drive, 4 x 3/16	4			
6	12451-041	SCREW, Machine, 6-32 x 1/4	4			
7	15220-045	GEAR, Spur	2			
8	15324-042	SCREW, Machine, 1/4-20 x 3/8	2			
9	16197-045	BUSHING, Eccentric	4			
10	16201-091	WASHER, Thrust	2			
11	16212-042	LOCKNUT	4			
12	16215-091	PIN	2			
13	16235-045	BUSHING	2			
14	16247-091	GEAR, Worm	1			
15	16284-042	STABILIZER	1			
16	16285-042	BEARING	1			
17	16299-091	WASHER	2			
18	16395-091	WASHER, Thrust	2			
19	16438-042	WASHER, Shaft	4			
20	16578-045	WASHER	6			
21	19684-061	LOCKWASHER	4			
22	20197-045	SPACER	3			
23	22266	ELEVATOR, Kidney (Sub: 56397-015)	1			
24	24700-061	PIN, Groove	3			
25	25834-091	SETSCREW	6			
26	26577-002	BUTTON, Plug	2			
27	43337-063	PIN, Hinge	2			
28	44440-063	PIN, Hinge	2			
29	44766	BEARING, Thrust (Sub: 50713-091)	2			
30	52715-091	SPACER	1			
31	52716-091	SPACER	1			
32	53328-042	BOX, Gear	1			
33	55100-091	SEAT SECTION ASSEMBLY (See Fig. 8-8)	1			
34	55104-091	LEG SECTION ASSEMBLY (See Fig. 8-7)	1			
35	55105-091	BACK SECTION ASSEMBLY (See Fig. 8-9)	1			
36	55114-001	BACK SECTION LEVER ARM ASSEMBLY (See Fig. 8-13)	1			
37	55114-002	LEG SECTION LEVER ARM ASSEMBLY (See Fig. 8-12)	1			
38	76253-063	SHAFT, Cross	1			
39	77555-091	SLEEVE	4			
40	77559-056	KNOB ASSEMBLY	4			
41	77730-061	BAR, Gear Rack	2			
42	78200-052	LINK	2			
43	78316-042	RACK	2			
44	150092-001	LOCKNUT	2			
45	133688-001	HEADREST ASSEMBLY (See Fig. 8-10)	1			

FIG & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
Sheet 2 of 3						
8-3A-						
46	2792-045	SCREW, Socket Head, 1/4-20 x 1/2	2			
47	3099-042	NUT, 3/8-16	1			
48	3516-041	WASHER	4			
49	3964-041	SCREW, Round Head, 6-32 x 5/8	2			
50	3967-041	SCREW, Machine, 8-32 x 1/4	1			
51	3984-041	SCREW, Round Head, 6-32 x 3/8	6			
52	3986-041	SCREW, Machine, 8-32 x 1/2	1			
53	3998-041	SCREW, Round Head, 1/4-20 x 1/2	4			
54	5590-042	WASHER, Flat	2			
55	5895-048	SCREW, Socket Head, 3/8-16 x 2	1			
56	8647-061	NUT, Hex, 10-32	3			
57	8897-091	PIN, Cotter	2			
58	12451-041	SCREW, Round Head, 6-32 x 1/4	6			
59	12531-061	SCREW, Round Head, 6-32 x 3/8 (Not Shown)	4			
60	12695-045	SCREW, Socket Head, 1/2-13 x 1-1/4	2			
61	12786-091	PIN, Taper	2			
62	13102-045	SCREW, Socket Head, 10-32 x 1	1			
63	13411-091	SCREW, Socket Head, 1/4-20 x 5/8	2			
64	15287-041	SCREW, Round Head, 10-32 x 1/2	1			
65	16082-041	NUT, Hex, 5/16-24	1			
66	16186-042	NUT, Adjusting	1			
67	16227-061	SHAFT	1			
68	16234-091	GEAR, Worm	1			
69	19675-041	LOCKWASHER, 6	4			
70	19678-045	LOCKWASHER, 1/4	6			
71	19685-061	LOCKWASHER, 10	4			
72	19687-061	LOCKWASHER, 3/8	3			
73	20200-045	JOINT, Universal	1			
74	24987-041	NUT, 1/4-20	1			
75	30092-061	PIN, Grooved, 5/32 x 3/4, ASA Type "C," Stainless Steel	1			
76	33061-061	SCREW, Socket Head, 10-32 x 5/8	4			
77	33281-061	WASHER	2			
78	34511-091	WASHER, Nylon	1			
79	36683-061	PIN, Roll	1			
80	37891-041	SCREW, Socket Head, 10-24 x 5/8	4			
81	39528-091	BEARING, Sleeve	1			
82	41012-061	SCREW, Socket Head	1			
83	41510-061	SCREW, Socket Head	1			
84	41511-061	PIN, Groove	2			
85	42566-091	PLUG, Pipe	2			
86	43223-091	SETSCREW, 10-32 x 1/4	1			
87	43227-061	PIN, Roll, 1/8 x 5/8, Steel	1			
88	43240-091	SCREW, Flat Head, 3/8-16 x 3/4	4			
89	43289-091	FITTING, Compression	2			
90	43300-061	PIN, Roll	2			
91	43306-091	CLEVIS	1			
92	43310-091	SCREW	1			
93	43313-045	ADJUSTER	1			
94	44766	BEARING, Thrust (Sub: 50713-091)	2			
95	45591-061	PIN	2			



FIG & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
Sheet 2 of 3						
8-3A-						
96	46123-010	SCREW, Flat Head Socket, 10-32 x 1/2 .....	3			
97	46156-061	PIN, Roll .....	4			
98	52306-091	NUT, Tinnerman, 6-32 .....	3			
99	52731-091	DECAL, Trendelenburg Tilt Indicator .....	1			
100	55039-091	SOLENOID ASSEMBLY (See Fig. 8-17) .....	1			
101	55123-091	SELECTOR, Worm Gear .....	1			
102	55135-056	BEZEL .....	2			
103	55142-001	LEVER, Power .....	1			
104	55150-091	VALVE ASSEMBLY (See Fig. 8-14) .....	1			
105	55280-001	BRACKET, Mounting .....	1			
106	74650-045	SCREW, Button Head Socket, 3/8-16 x 5/8 .....	4			
107	75381-091	SCREW, Flat Head, 6-32 x 3/4 .....	3			
108	76613-091	ELL, Special .....	2			
109	76801-045	LOCKWASHER, 10 .....	3			
110	77551-061	KIDNEY ELEVATOR SHAFT .....	1			
111	77673-045	ROD, Valve Operating .....	1			
112	77674-045	ROD, Valve Operating .....	1			
113	77675-061	ROD, Connecting .....	1			
114	77682-045	STOP, Lever .....	4			
115	78132-045	NUT, Jam 5/16-24 .....	1			
116	78164-091	TUBE, Nylaflo .....	1			
117	78165-091	TUBE, Nylaflo .....	1			
118	78281-045	ROD, Control .....	1			
119	78292-091	FITTING, Compression .....	2			
120	78299-091	TUBE, Copper .....	1			
121	78300-091	TUBE, Copper .....	1			
122	80001-091	SETSCREW, 1/4-20 x 1/2 .....	2			
123	80192-091	SCREW, Swivel Head, 1/4-20 x 1/2 .....	1			
124	80193-091	SCREW, Swivel Head, 1/4-20 x 3/4 .....	1			
125	80200-045	BAR, Restraint .....	1			
126	80222-061	SCREW, Button Head, 3/8-16 x 1-1/2 .....	3			
127	80904-091	SELECTOR ASSEMBLY .....	1			
128	81005-091	INSULATOR .....	1			
129	81010-091	CONNECTOR .....	2			
130	81015-045	NUT, Tinnerman, 10-32 .....	1			
131	89617-061	WASHER .....	2			
132	90514-091	CLAMP, Tube .....	1			
133	92588-001	KIDNEY ELEVATOR CRANK ASSEMBLY (See Fig. 8-18A) .....	1			
134	97190-091	COVER, Terminal .....	1			
135	133676-001	SHAFT AND BEARING ASSEMBLY (See Fig. 8-16) .....	1			
136	134067-006	SIDE FRAME ASSEMBLY (See Fig. 8-20) .....	1			
137	135241-001	PLATE, Trendelenburg .....	1			
138	135242-001	COVER AND STUD ASSEMBLY .....	1			
139	135983-001	SUPPORT ASSEMBLY (See Fig. 8-19A) .....	1			
140	150169-001	MOTOR, Hydraulic (Orbit) .....	1			
141	163688-001	SOLENOID COVER ASSEMBLY .....	1			

FIG & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
Sheet 3 of 3						
8-3A-						
142	R-1215-025	TUBE, Washing, 1/4 O.D., 2 ft. ....	A/R			
143	R-7200-426	GASKET, Scotch Foam Single Coated Black Tape, 1/8 x 3/8 ....	A/R			
144	R-7200	GASKET, Scotch Foam 1/4 x 1/4 (Sub: 764317-529).....	A/R			
145	3961-041	SCREW, Flat Head, 6-32 x 3/8 .....	6			
146	3984-041	SCREW, Round Head, 6-32 x 3/8 .....	6			
147	9655-091	SETSCREW, 3/8-16 x 5/8 .....	1			
148	12423-041	SCREW, Socket Head Cap, 5/16-18 x 3/4 .....	3			
149	12531-061	SCREW, Round Head, 6-32 x 3/8 .....	4			
150	13103-001	RELIEF, Strain .....	3			
150A	15294-091	PIN, Dowel .....	2			
151	16405-091	BEARING, Needle .....	3			
152	16416-091	KEY, Woodruff .....	1			
153	16424-091	PIN, Dowel .....	8			
154	17918-091	LOCKWASHER .....	3			
155	19686-061	LOCKWASHER .....	4			
156	25832-041	LOCKWASHER .....	12			
157	30379-041	SCREW, Flat Head, 8-32 x 5/8 .....	3			
158	30718-044	ELL, Compression .....	2			
159	36565-061	PIN, Roll .....	1			
160	43240-091	SCREW, Flat Head, 3/8-16 x 3/4 .....	8			
161	43247-091	LEVER, Control Assembly .....	1			
162	43266-061	PIN, Roll .....	1			
163	43282-091	SETSCREW, Nylock, 10-32 x 5/16 .....	2			
164	44743-041	SCREW, Cap, 3/8-16 x 5/8 .....	2			
165	44747-042	SCREW, Cap, 3/8-16 x 2 .....	10			
166	46156-061	PIN, Roll .....	4			
167	47161-091	NUT, Tinnerman, 8-32 .....	3			
168	48060-091	SCREW, Socket Head Cap, 1/4-20 x 3/4 .....	8			
169	52697-091	ELBOW, Male, 45 .....	4			
170	52698-061	SCREW, Socket Head, 10-32 x 2-3/4 .....	4			
171	52729-001	DECAL, Position Indicator .....	1			
172	55134-031	CHANNEL .....	1			
173	55135-056	BEZEL .....	1			
174	55141-091	SUPPORT, Shift Handle .....	1			
175	55142-001	LEVER, Power .....	1			
176	55276-001	SHIFTER FORK ASSEMBLY .....	1			
177	55280-001	BRACKET, Mounting .....	1			
178	†	VALVE, Directional .....	1			
179	74650-045	SCREW, Button Head Socket, 3/8-16 x 5/8 .....	4			
180	75828-091	BEARING, Thrust .....	3			
181	75829-091	RACE, Thrust Bearing .....	6			
182	75870-091	BEARING, Sleeve .....	1			
183	77658-091	SCREW, Shoulder .....	1			
184	77662-056	INDICATOR .....	1			
†NOTE: The directional valve 80540-091 was discontinued in October, 1976. The valve 56191-001 was discontinued in November, 1977. To replace either valve, order kit Q-763702-001. The new valve is a double "A" valve.						

FIG & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
Sheet 3 of 3						
8-3A-						
185	77671-045	BRACKET AND ROD ASSEMBLY .....	1			
186	77676-091	LEVER ASSEMBLY .....	1			
187	77686-061	PIN, Crank .....	1			
188	78171	TUBE, Nylaflow (Sub: 150579-001) .....	1			
189	78173	TUBE, Nylaflow (Sub: 150578-001) .....	1			
190	78208	PLATE, Sub ... (Sub: 150524-001) .....	1			
191	78279-091	CRANK .....	1			
192	78399-091	TUBE, Nylaflow .....	1			
193	80001-091	SETSCREW, 1/4-20 x 1/2 .....	2			
194	80110-091	BEARING, Needle .....	3			
195	80195-091	TUBE, Nylaflow .....	1			
196	80915-045	NUT, Tensilock, 3/8-16 .....	1			
197	81006-091	INSULATOR .....	1			
198	81596-001	PIN, Support .....	1			
199	97188-010	COVER, Relay Box .....	1			
200	97189-091	COVER, Switch .....	1			
201	99428-091	SELECTOR ASSEMBLY (See Fig. 8-24) .....	1			
202	+99930-001	SIDE DRIVE ASSEMBLY (See Fig. 8-21) .....	1			
203	118153-091	CLAMP, Cable .....	1			
204	133645-010	SADDLE, Side Tilt .....	1			
205	133664-002	COVER, Drive .....	1			
206	133691-001	COPPER TUBE ASSEMBLY .....	1			
207	133692-001	COPPER TUBE ASSEMBLY .....	1			
208	136210-001	SIDE TILT SCREW ASSEMBLY (See Fig. 8-23) .....	1			
209	150169-001	MOTOR, Hydraulic (Orbit) .....	1			
210	163521-091	RELAY BOX ASSEMBLY (See Fig. 8-5) .....	1			
†NOTE 1: 99930-001 used on units before 1/75. 99930-001 deleted and parts transferred to 134186-001, 134187-001, 134188-001, 134189-001 and 150125-001 on units shipped after 1/75.						

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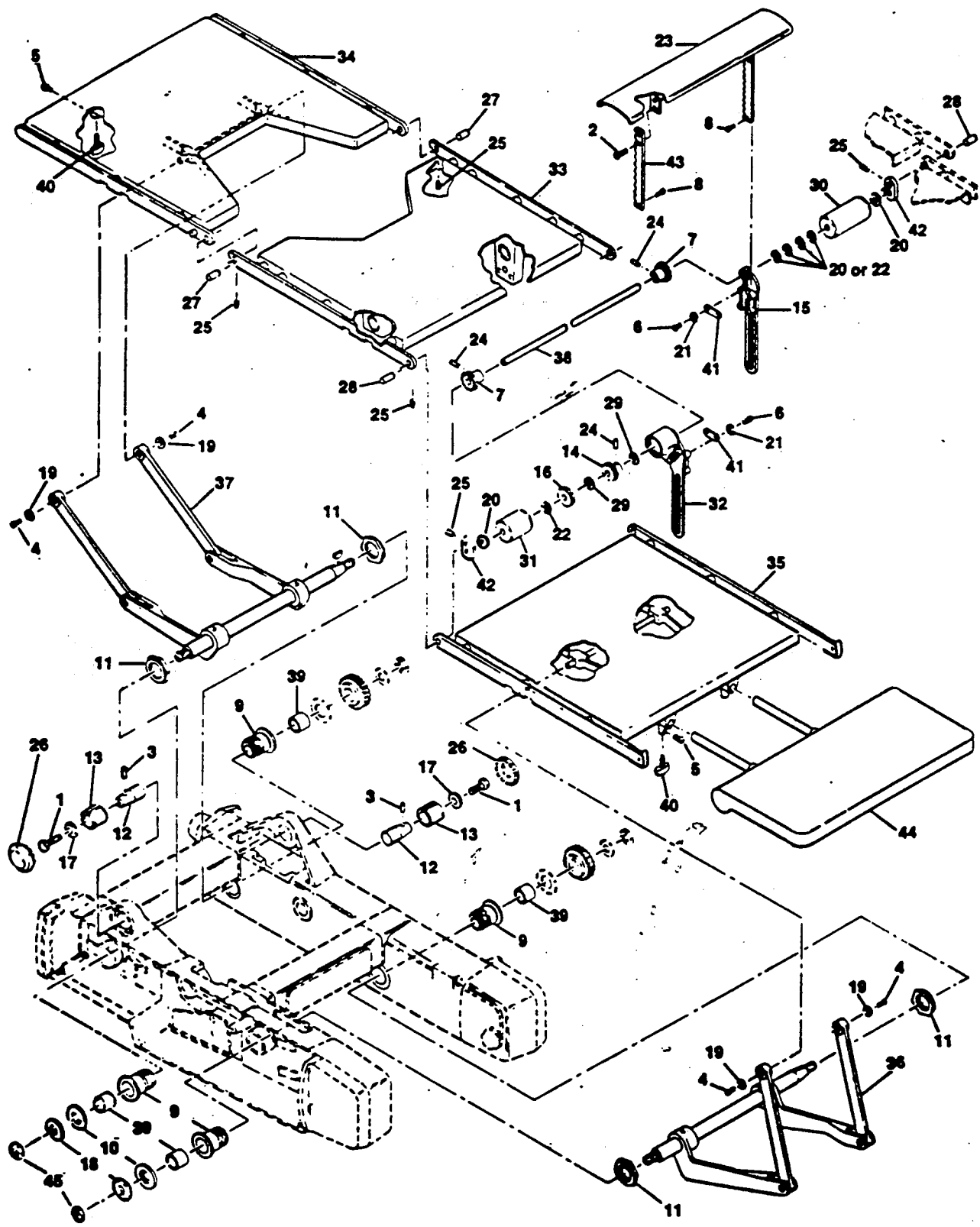


Figure 8-4. 2080L TABLETOP ASSEMBLY  
UNITS SHIPPED BEFORE 8/74 (Sheet 1 of 3).

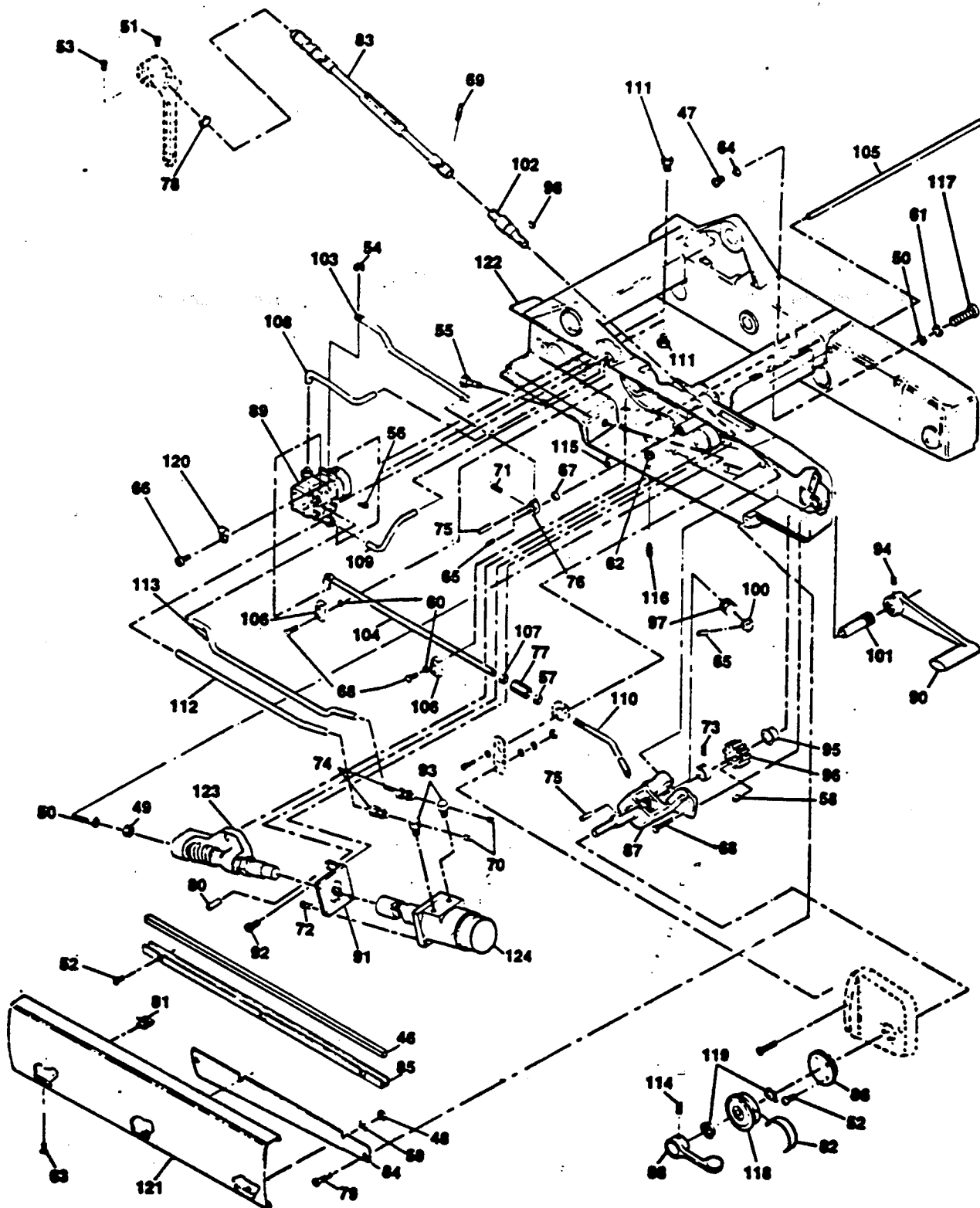
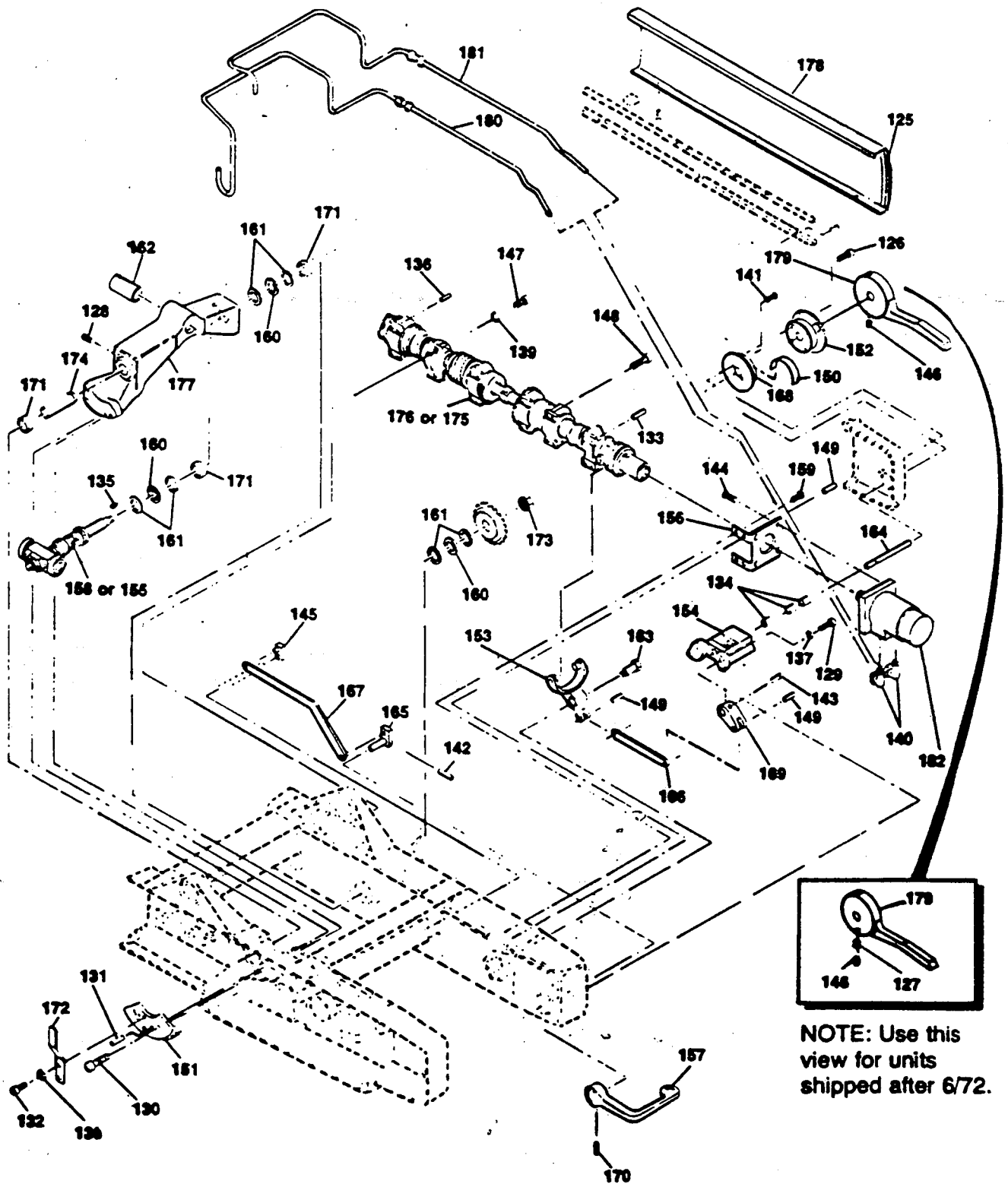


Figure 8-4. 2080L TABLETOP ASSEMBLY  
UNITS SHIPPED BEFORE 8/74 (Sheet 2 of 3).



†See Parts List.

Figure 8-4. 2080L TABLETOP ASSEMBLY  
UNITS SHIPPED BEFORE 8/74 (Sheet 3 of 3).

FIG & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
8-4-	99427-001	2080L TABLETOP ASSEMBLY (Units Shipped Before 8/74)				
		Sheet 1 of 3				
1	3902-041	SCREW, Hex Head, 3/8-16 x 1 .....	1			
2	3949-042	SCREW, 1/4-20 x 3/4 .....	1			
3	8873-045	PIN, Tube Link .....	1			
4	9282-041	SCREW, Flat Head, 10-32 x 3/8 .....	4			
5	9645-061	SCREW, Drive .....	4			
6	12451-041	SCREW, Round Head, 6-32 x 1/4 .....	4			
7	15220-045	GEAR, Spur .....	2			
8	15324-042	SCREW, Machine, 1/4-20 x 3/8 .....	2			
9	16197-045	BUSHING, Eccentric .....	4			
10	16201-091	WASHER, Thrust .....	2			
11	16212-042	LOCKNUT .....	4			
12	16215-091	PIN .....	2			
13	16235-045	BUSHING .....	2			
14	16247-091	GEAR, Worm .....	1			
15	16284-042	STABILIZER .....	1			
16	16285-042	BEARING .....	1			
17	16299-091	WASHER .....	2			
18	16395-091	WASHER, Thrust .....	2			
19	16438-042	WASHER, Shaft .....	4			
20	16578-045	WASHER .....	6			
21	19684-061	LOCKWASHER .....	4			
22	20197-045	SPACER .....	3			
23	22266	ELEVATOR, Kidney (Sub: 56397-015) .....	1			
24	24700-061	PIN, Groove .....	3			
25	25834-091	SETSCREW .....	6			
26	26577-002	BUTTON, Plug .....	2			
27	43337-063	PIN, Hinge .....	2			
28	44440-063	PIN, Hinge .....	2			
29	44766	BEARING, Thrust (Sub: 50713-091) .....	2			
30	52715-091	SPACER .....	1			
31	52716-091	SPACER .....	1			
32	53328-042	BOX, Gear .....	1			
33	55100-091	SEAT SECTION ASSEMBLY (See Fig. 8-8) .....	1			
34	55104-091	LEG SECTION ASSEMBLY (See Fig. 8-7) .....	1			
35	55105-091	BACK SECTION ASSEMBLY (See Fig. 8-9) .....	1			
36	55114-001	BACK SECTION LEVER ARM ASSEMBLY (See Fig. 8-13) .....	1			
37	55114-002	LEG SECTION LEVER ARM ASSEMBLY (See Fig. 8-12) .....	1			
38	76253-063	SHAFT, Cross .....	1			
39	77555-091	SLEEVE .....	4			
40	77559-056	KNOB ASSEMBLY .....	4			
41	77730-061	BAR, Gear Rack .....	2			
42	78200-052	LINK .....	2			
43	78316-042	RACK .....	2			
44	133688-001	HEADREST ASSEMBLY (See Fig. 8-10) .....	1			
45	150092-001	LOCKNUT .....	2			

FIG & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
Sheet 2 of 3						
8-4-						
46	R-7200	GASKET, Scotch Foam, 1/4 x 1/4 (Sub: 764317-529).....	A/R			
47	2792-045	SCREW, Socket Head, Cap 1/4-20 x 1/2 .....	2			
48	2960-042	NUT, Hex, 10-32 .....	2			
49	3099-042	NUT, 3/8-16 .....	1			
50	3516-041	WASHER .....	4			
51	3967-041	SCREW, Machine, 8-32 x 1/4 .....	1			
52	3984-041	SCREW, Round Head, 6-32 x 3/8 .....	10			
53	3986-041	SCREW, Machine, 8-32 x 1/2 .....	1			
54	5590-042	WASHER, Flat .....	2			
55	5895-048	SCREW, Socket Head Cap, 3/8-16 x 2 .....	1			
56	8897-091	PIN, Cotter .....	2			
57	16082-041	NUT, Hex, 5/16-24 .....	1			
58	16416-091	KEY, Woodruff .....	1			
59	19677-041	LOCKWASHER .....	2			
60	19685-061	LOCKWASHER, 10 .....	4			
61	19687-061	LOCKWASHER, 3/8 .....	3			
62	24987-041	NUT, 1/4-20 .....	1			
63	30379-041	SCREW, Flat Head, 8-32 x 5/8 .....	3			
64	33281-061	WASHER .....	2			
65	36683-061	PIN, Roll .....	2			
66	37891-041	SCREW, Socket Head, 10-24 x 5/8 .....	4			
67	39528-091	BEARING, Sleeve .....	1			
68	41012-061	SCREW, Socket Head, 10-32 x 1/2 .....	8			
69	41511-061	PIN, Groove .....	1			
70	42566-091	PLUG, Pipe .....	2			
71	43223-091	SETSCREW, 10-32 x 1/4 .....	1			
72	43240-091	SCREW, Flat Head, 3/8-16 x 3/4 .....	8			
73	43282-091	SETSCREW, 10-32 x 5/16 .....	1			
74	43289-091	FITTING, Compression .....	2			
75	43300-061	PIN, Roll .....	2			
76	43306-091	CLEVIS .....	1			
77	43313-045	ADJUSTER .....	1			
78	44766	BEARING, Thrust (Sub: 50713-091) .....	1			
79	46123-010	SCREW, Flat Head Socket, 10-32 x 1/2 .....	2			
80	46156-061	PIN, Roll .....	6			
81	47161-091	NUT, Tinnerman .....	4			
82	52731-091	DECAL, Trendelenburg Tilt Indicator .....	1			
83	55095-091	KIDNEY ELEVATOR SHAFT ASSEMBLY (See Fig. 8-20) .....	1			
84	55129-010	PLATE .....	1			
85	55134-061	CHANNEL .....	1			
86	55135-056	BEZEL .....	1			
87	55138-091	SUPPORT ASSEMBLY (See Fig. 8-19) .....	1			
88	55142-001	LEVER, Power .....	1			
89	55149-091	VALVE ASSEMBLY (See Fig. 8-15) .....	1			



FIG & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
Sheet 2 of 3						
8-4-						
90	55269-001	KIDNEY ELEVATOR HANDLE RATCHET ASSEMBLY (See Fig. 8-18) ..	1			
91	55280-045	BRACKET, Mounting .....	1			
92	74650-045	SCREW, Button Head Socket, 3/8-16 x 5/8 .....	4			
93	76613-091	ELL, Special .....	2			
94	77561-061	SETSCREW, 10-24 x 1/4 .....	1			
95	77570-091	BEARING, Flange .....	1			
96	NLA	GEAR, Worm (77571) .....	1			
97	NLA	GEAR, Helical (77572) .....	1			
98	77573-091	KEY, Woodruff .....	1			
99	77579-091	RING, Stop (Not Shown) .....	1			
100	77580-091	RING, Stop .....	1			
101	NLA	SHAFT, Kidney Drive (77585) .....	1			
102	77656-061	SHAFT, Pinion .....	1			
103	77673-045	ROD, Valve Operating .....	1			
104	77674-045	ROD, Valve Operating .....	1			
105	77675-061	ROD, Connecting .....	1			
106	77682-045	STOP, Lever .....	2			
107	78132-045	NUT, Jam, 5/16-24 .....	1			
108	78164-091	TUBE, Nylaflo .....	1			
109	78165-091	TUBE, Nylaflo, .....	1			
110	78281-045	ROD, Control .....	1			
111	78292-091	FITTING, Compression .....	2			
112	78299-091	TUBE, Copper .....	1			
113	78300-091	TUBE, Copper .....	1			
114	80001-091	SETSCREW, 1/4-20 x 1/2 .....	2			
115	80192-091	SCREW, Swivel Head .....	1			
116	80193-091	SCREW, Swivel Head .....	1			
117	80222-061	SCREW, Button Head, 3/8-16 x 1-1/2 .....	3			
118	80904-091	SELECTOR ASSEMBLY .....	1			
119	89617-061	WASHER .....	2			
120	90514-091	CLAMP, Tube .....	1			
121	133665-002	COVER ASSEMBLY .....	1			
122	133670-002	SIDE FRAME ASSEMBLY .....	1			
123	133676-001	TRENDELENBURG SHAFT AND BEARING ASSEMBLY (See Fig. 8-16)	1			
124	150169-001	MOTOR, Hydraulic (Orbit) .....	1			
Sheet 3 of 3						
125	R-7200-426	GASKET, Scotch Foam Single Coated Black Tape, 1/8 x 3/8 .....	A/R			
126	3984-041	SCREW, Round Head, 6-32 x 3/8 .....	6			
127	5831-091	SETSCREW, Hex Socket Cone Point (Units Shipped After 6/72) .....	2			
128	9655-091	SETSCREW, 3/8-16 x 5/8 .....	1			
129	12423-041	SCREW, Socket Head Cap, 5/16-18 x 3/4 .....	3			
130	12695-045	SCREW, Socket Head, 1/2-13 x 1-1/4 .....	2			
131	12786-091	PIN, Taper .....	2			
132	13411-091	SCREW, Socket Head, 1/4-20 x 5/8 .....	2			
133	15294-091	PIN, Dowel .....	2			
134	16405-091	BEARING, Needle .....	3			
135	16416-091	KEY, Woodruff .....	1			
136	16424-091	PIN, Dowel .....	8			

FIG & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
Sheet 3 of 3						
8-4-						
137	17918-091	LOCKWASHER .....	3			
138	19678-045	LOCKWASHER .....	6			
139	25832-041	LOCKWASHER .....	12			
140	30718-044	ELL, Compression .....	2			
141	42603-091	SCREW, Round Head, 6-32 x 7/8 .....	2			
142	43227-061	PIN, Roll .....	2			
143	43229-061	PIN, Roll .....	1			
144	43240-091	SCREW, Flat Head, 3/8-16 x 3/4 .....	8			
145	43247-091	CONTROL LEVER ASSEMBLY .....	1			
146	43282-091	SETSCREW .....	2			
147	44743-041	SCREW, Cap, 3/8-16 x 5/8 .....	2			
148	44747-042	SCREW, Cap, 3/8-16 x 2 .....	10			
149	46156-061	PIN, Roll .....	4			
150	52729-001	DECAL, Position Indicator .....	1			
151	55123-091	SECTOR, Worm Gear .....	1			
152	55135-056	BEZEL .....	1			
153	55140-001	SHIFTER FORK ASSEMBLY .....	1			
154	55141-091	SUPPORT, Shifter .....	1			
155	55122-001	SIDE TILT SCREW ASSEMBLY (Units Shipped Before 6/72) (See Fig. 8-23) .....	1			
156	55280-045	BRACKET, Mounting .....	1			
157	55364-001	LEVER, Power .....	1			
158	56049-001	SIDE TILT SCREW ASSEMBLY (Units Shipped After 6/72) (See Fig. 8-23) .....	1			
159	74650-045	SCREW, Button Head Socket, 3/8-16 x 5/8 .....	4			
160	75828-091	BEARING, Thrust .....	3			
161	75829-091	RACE, Thrust Bearing .....	6			
162	75870-091	BEARING, Sleeve .....	1			
163	77658-091	SCREW, Shoulder .....	1			
164	77664-061	PIN, Crank .....	1			
165	77671-045	BRACKET AND ROD ASSEMBLY .....	1			
166	77672-042	ROD, Connecting .....	1			
167	77676-091	LEVER ASSEMBLY .....	1			
168	77684-056	SPACER, Bezel .....	1			
169	77685-091	CRANK .....	1			
170	80001-091	SETSCREW, 1/4-20 x 1/2 .....	2			
171	80110-091	BEARING, Needle .....	3			
172	80200-045	BAR, Restraint .....	1			
173	80915-045	NUT, Tensilock .....	1			
174	81596-001	PIN, Support .....	1			
175	99315-003	SIDE DRIVE ASSEMBLY (Units Shipped Before 2/71) (See Fig. 8-21) ..	1			
176	99930-003	SIDE DRIVE ASSEMBLY (Units Shipped After 2/71) (See Fig. 8-21) ....	1			
177	133645-010	SADDLE, Side Tilt .....	1			
178	133664-002	COVER, Drive .....	1			
179	133671-002	HANDLE, Select .....	1			
180	133691-001	COPPER TUBE ASSEMBLY .....	1			
181	133692-001	COPPER TUBE ASSEMBLY .....	1			
182	150169-001	MOTOR, Hydraulic (Orbit) .....	1			

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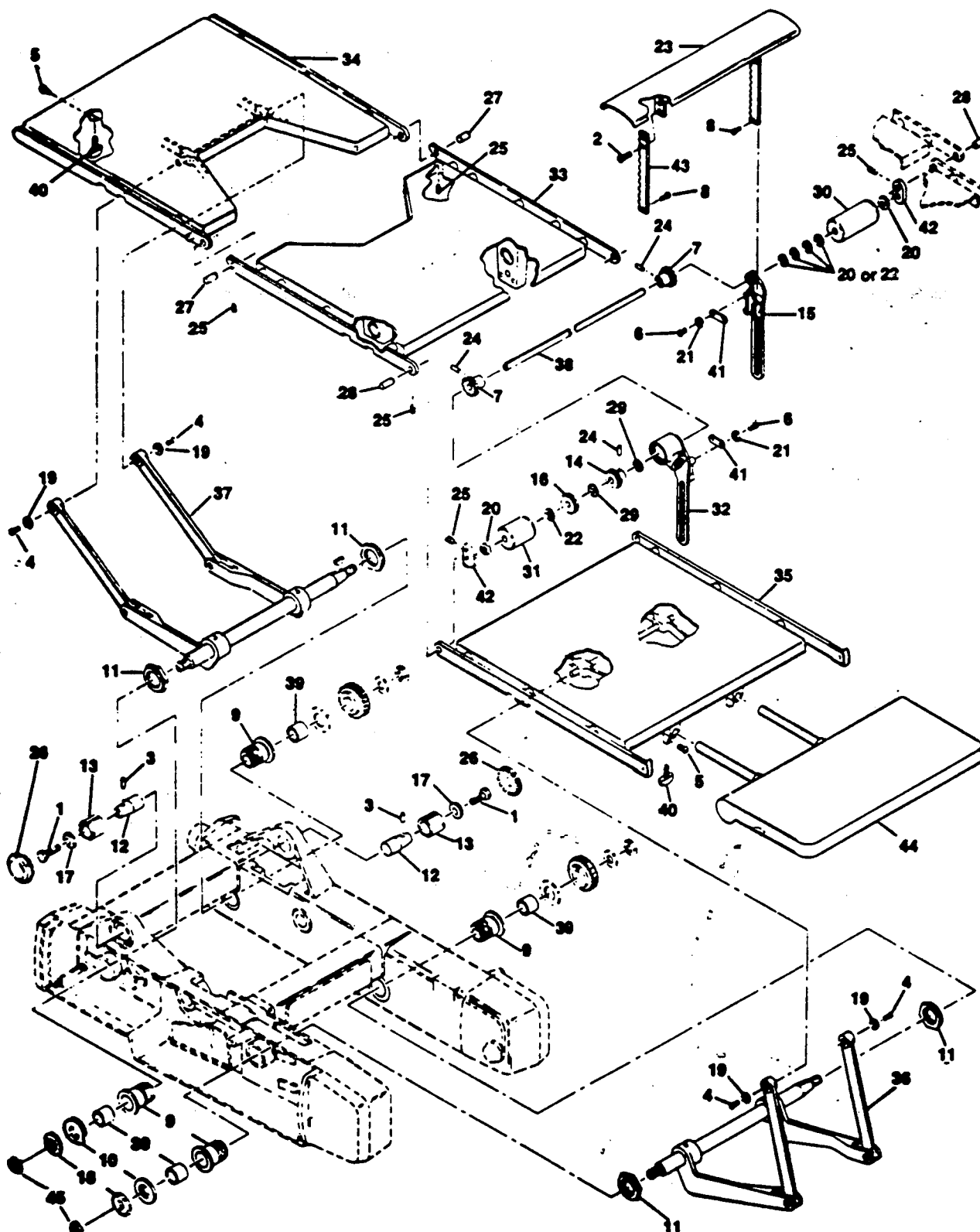


Figure 8-4A. 2080L AND 2080 COMPAT TABLETOP ASSEMBLY  
UNITS SHIPPED AFTER 8/74 (Sheet 1 of 3).

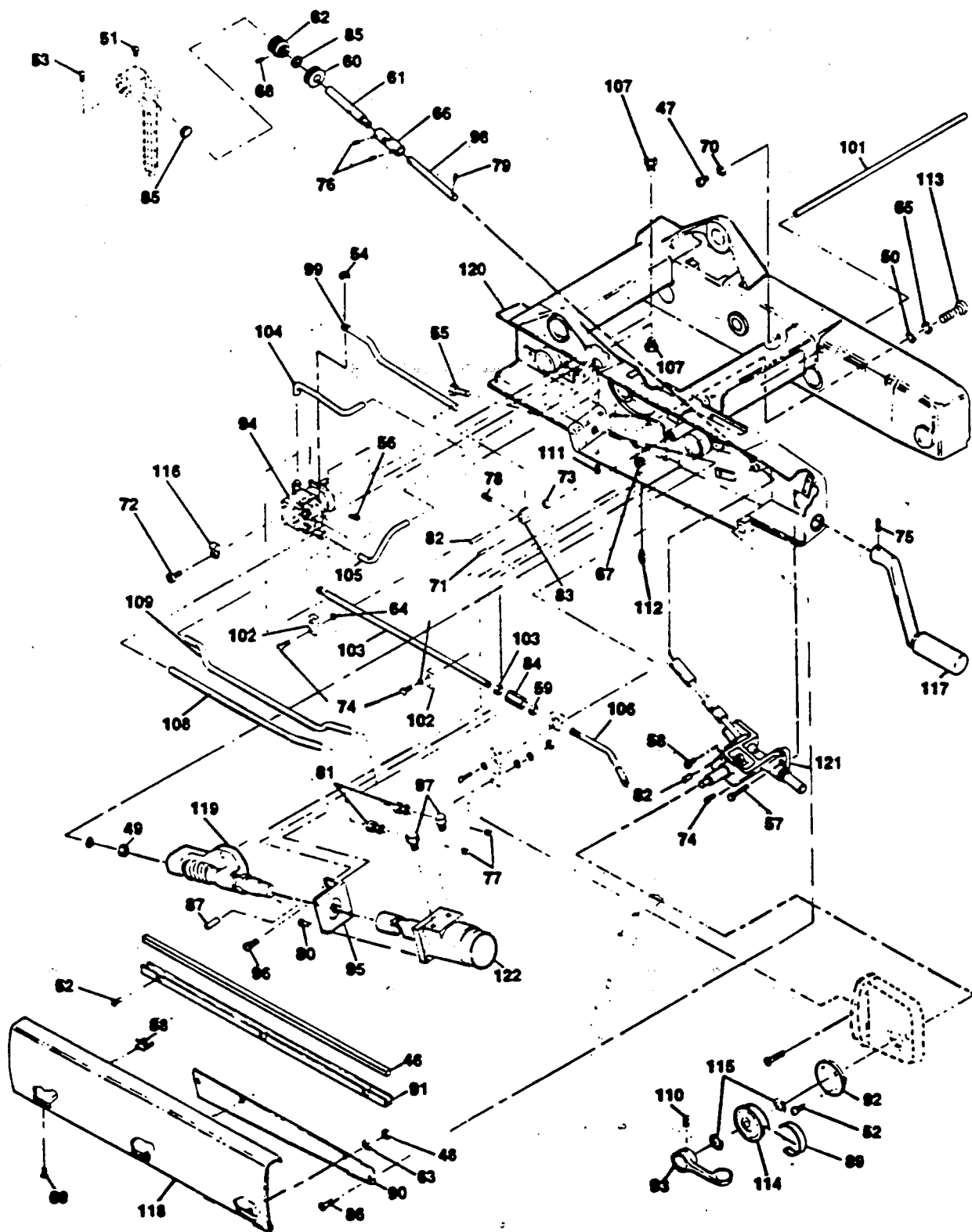
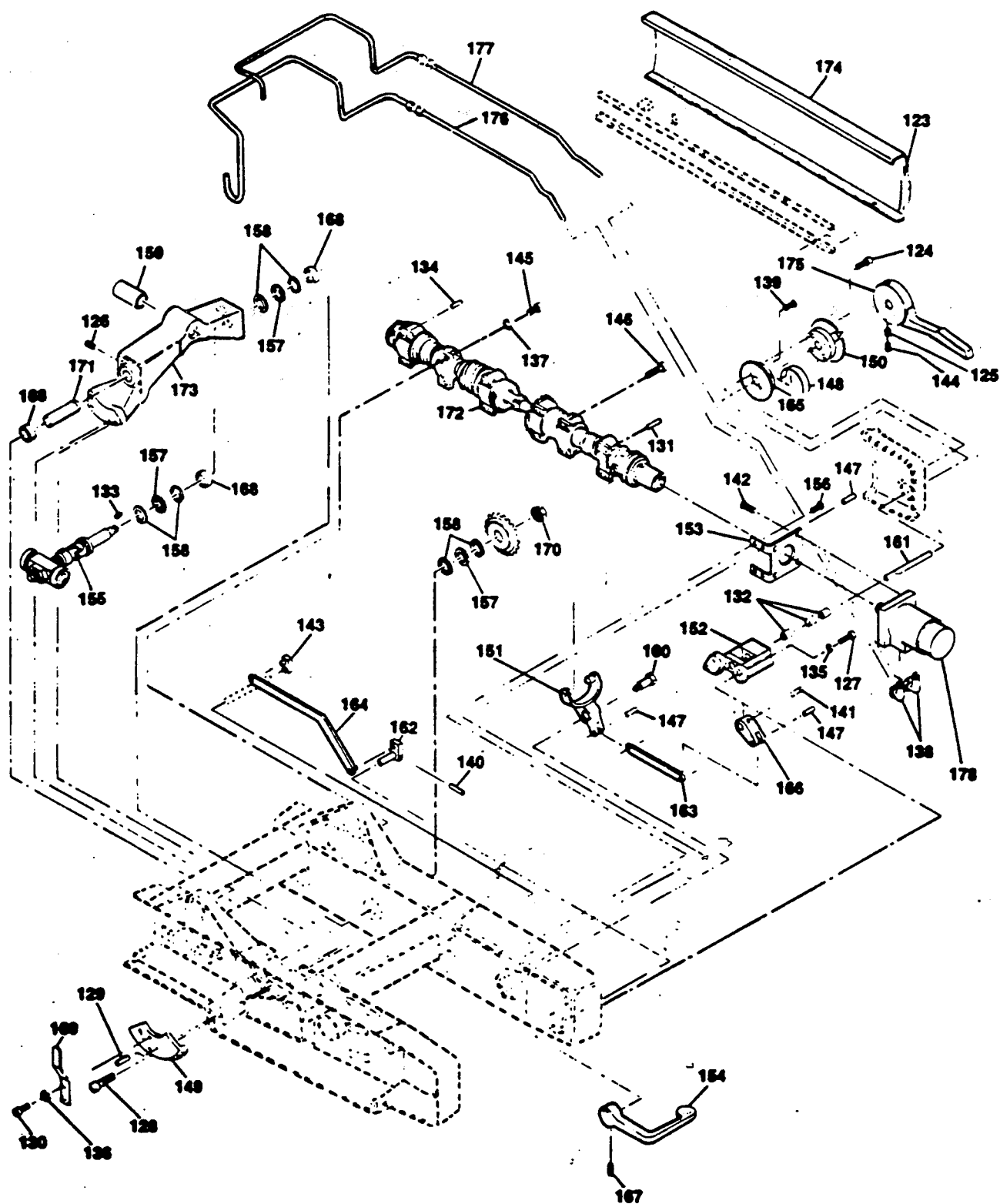


Figure 8-4A. 2080L AND 2080 COMPAT TABLETOP ASSEMBLY  
UNITS SHIPPED AFTER 8/74 (Sheet 2 of 3).



**Figure 8-4A. 2080L AND 2080 COMPAT TABLETOP ASSEMBLY  
UNITS SHIPPED AFTER 8/74 (Sheet 3 of 3).**

†See Parts List.

FIG & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
8-4A-	99934-002	2080L AND 2080 COMPAT TABLETOP ASSEMBLY (Units Shipped After 8/74)				
		Sheet 1 of 3				
1	3902-041	SCREW, Hex Head, 3/8-16 x 1 .....	1			
2	3949-042	SCREW, 1/4-20 x 3/4 .....	1			
3	8873-045	PIN, Tube Link .....	1			
4	9282-041	SCREW, Flat Head, 10-32 x 3/8 .....	4			
5	9645-061	SCREW, Drive .....	4			
6	12451-041	SCREW, Round Head, 6-32 x 1/4 .....	4			
7	15220-045	GEAR, Spur .....	2			
8	15324-042	SCREW, Machine, 1/4-20 x 3/8 .....	2			
9	16197-045	BUSHING, Eccentric .....	4			
10	16201-091	WASHER, Thrust .....	2			
11	16212-042	LOCKNUT .....	4			
12	16215-091	PIN .....	2			
13	16235-045	BUSHING .....	2			
14	16247-091	GEAR, Worm .....	1			
15	16284-042	STABILIZER .....	1			
16	16285-042	BEARING .....	1			
17	16299-051	WASHER .....	2			
18	16395-091	WASHER, Thrust .....	2			
19	16438-042	WASHER, Shaft .....	4			
20	16578-045	WASHER .....	6			
21	19684-061	LOCKWASHER .....	4			
22	20197-045	SPACER .....	3			
23	22266	ELEVATOR, Kidney (Sub: 56397-015) .....	1			
24	24700-061	PIN, Groove .....	3			
25	25834-091	SETSCREW .....	6			
26	26577-002	BUTTON, Plug .....	2			
27	43337-063	PIN, Hinge .....	2			
28	44440-063	PIN, Hinge .....	2			
29	44766	BEARING, Thrust (Sub: 50713-091) .....	2			
30	52715-091	SPACER .....	1			
31	52716-091	SPACER .....	1			
32	53328-042	BOX, Gear .....	1			
33	55100-091	SEAT SECTION ASSEMBLY (See Fig. 8-8) .....	1			
34	55104-091	LEG SECTION ASSEMBLY (See Fig. 8-7) .....	1			
35	55105-091	BACK SECTION ASSEMBLY (See Fig. 8-9) .....	1			
36	55114-001	BACK SECTION LEVER ARM ASSEMBLY (See Fig. 8-13) .....	1			
37	55114-002	LEG SECTION LEVER ARM ASSEMBLY (See Fig. 8-12) .....	1			
38	76253-063	SHAFT, Cross .....	1			
39	77555-091	SLEEVE .....	4			
40	77559-056	KNOB ASSEMBLY .....	4			
41	77730-061	BAR, Gear Rack .....	2			
42	78200-052	LINK .....	2			
43	78316-042	RACK .....	2			
44	133688-001	HEADREST ASSEMBLY (See Fig. 8-10) .....	1			
45	150092-001	LOCKNUT .....	2			

FIG & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
Sheet 2 of 3						
8-4A-						
46	R-7200	GASKET, Scotch Foam, 1/4 x 1/4 (Sub: 764317-529).....	A/R			
47	2792-045	SCREW, Socket Head Cap, 1/4-20 x 1/2 .....	2			
48	2960-042	NUT, Hex, 10-32 .....	2			
49	3099-042	NUT, 3/8-16 .....	1			
50	3516-041	WASHER .....	4			
51	3967-041	SCREW, Machine, 8-32 x 1/4 .....	1			
52	3984-041	SCREW, Round Head, 6-32 x 3/8 .....	10			
53	3986-041	SCREW, Machine, 8-32 x 1/2 .....	1			
54	5590-042	WASHER, Flat .....	2			
55	5895-048	SCREW, Socket Head Cap, 3/8-16 x 2 .....	1			
56	8897-091	PIN, Cotter .....	2			
57	13102-045	SCREW, Socket Head, 10-32 x 1 .....	1			
58	15287-041	SCREW, Round Head, 10-32 x 1/2 .....	1			
59	16082-041	NUT, Hex, 5/16-24 .....	1			
60	16186-042	NUT, Adjusting .....	1			
61	16227-061	SHAFT .....	1			
62	16234-091	GEAR, Worm .....	1			
63	19677-041	LOCKWASHER .....	2			
64	19685-061	LOCKWASHER, 10 .....	4			
65	19687-061	LOCKWASHER, 3/8 .....	3			
66	20200-045	JOINT, Universal .....	1			
67	24987-041	NUT, 1/4-20 .....	1			
68	30092-061	PIN, Grooved, 5/32 x 3/4, ASA Type "C," Stainless Steel .....	1			
69	30379-041	SCREW, Flat Head, 8-32 x 5/8 .....	3			
70	33281-061	WASHER .....	2			
71	36683-061	PIN, Roll .....	1			
72	37891-041	SCREW, Socket Head, 10-24 x 5/8 .....	4			
73	39528-091	BEARING, Sleeve .....	1			
74	41012-061	SCREW, Socket Head, 10-32 x 1/2 .....	5			
75	41510-061	PIN, Groove .....	1			
76	41511-061	PIN, Groove .....	2			
77	42566-091	PLUG, Pipe .....	2			
78	43223-091	SETSCREW, 10-32 x 1/4 .....	1			
79	43227-061	PIN, Roll, 1/8 x 5/8, Steel .....	1			
80	43240-091	SCREW, Flat Head, 3/8-16 x 3/4 .....	8			
81	43289-091	FITTING, Compression .....	2			
82	43300-061	PIN, Roll .....	2			
83	43306-091	CLEVIS .....	1			
84	43313-045	ADJUSTER .....	1			
85	44766	BEARING, Thrust (Sub: 50713-091) .....	2			
86	46123-010	SCREW, Flat Head Socket, 10-32 x 1/2 .....	2			
87	46156-061	PIN, Roll .....	6			
88	47161-091	NUT, Tinnerman .....	4			
89	52731-091	DECAL, Trendelenburg Tilt Indicator .....	1			
90	55129-010	PLATE .....	1			
91	55134-031	CHANNEL .....	1			
92	55135-056	BEZEL .....	1			
93	55142-001	LEVER, Power .....	1			
94	55149-091	VALVE ASSEMBLY (See Fig. 8-15) .....	1			

FIG & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
Sheet 2 of 3						
8-4A-						
95	55280-045	BRACKET, Mounting .....	1			
96	74650-045	SCREW, Button Head Socket, 3/8-16 x 5/8 .....	4			
97	76613-091	ELL, Special .....	2			
98	77551-061	KIDNEY ELEVATOR SHAFT .....	1			
99	77673-045	ROD, Valve Operating .....	1			
100	77674-045	ROD, Valve Operating .....	1			
101	77675-061	ROD, Connecting .....	1			
102	77682-045	STOP, Lever .....	2			
103	78132-045	NUT, Jam, 5/16-24 .....	1			
104	78164-091	TUBE, Nylaflo .....	1			
105	78165-091	TUBE, Nylaflo .....	1			
106	78281-045	ROD, Control .....	1			
107	78292-091	FITTING, Compression .....	2			
108	78299-091	TUBE, Copper .....	1			
109	78300-091	TUBE, Copper .....	1			
110	80001-091	SETSCREW, 1/4-20 x 1/2 .....	2			
111	80192-091	SCREW, Swivel Head .....	1			
112	80193-091	SCREW, Swivel Head .....	1			
113	80222-061	SCREW, Button Head, 3/8-16 x 1-1/2 .....	3			
114	80904-091	SELECTOR ASSEMBLY .....	1			
115	89617-061	WASHER .....	2			
116	90514-091	CLAMP, Tube .....	1			
117	92588-001	KIDNEY ELEVATOR CRANK ASSEMBLY (See Fig. 8-18A) .....	1			
118	133665-002	COVER ASSEMBLY .....	1			
119	133676-001	TRENDELENBURG SHAFT AND BEARING ASSEMBLY (See Fig. 8-16) .....	1			
120	134067-005	SIDE FRAME ASSEMBLY .....	1			
121	135983-001	SUPPORT ASSEMBLY (See Fig. 8-19A) .....	1			
122	150169-001	MOTOR, Hydraulic (Orbit) .....	1			
Sheet 3 of 3						
123	R-7200-426	GASKET, Scotch Foam Single Coated Black Tape, 1/8 x 3/8 .....	A/R			
124	3984-041	SCREW, Round Head, 6-32 x 3/8 .....	6			
125	5831-091	SETSCREW, Hex Socket Cone Point .....	2			
126	9655-091	SETSCREW, 3/8-16 x 5/8 .....	1			
127	12423-041	SCREW, Socket Head Cap, 5/16-18 x 3/4 .....	3			
128	12695-045	SCREW, Socket Head, 1/2-13 x 1-1/4 .....	2			
129	12786-091	PIN, Taper .....	2			
130	13411-091	SCREW, Socket Head, 1/4-10 x 5/8 .....	2			
131	15294-091	PIN, Dowel .....	2			
132	16405-091	BEARING, Needle .....	3			
133	16416-091	KEY, Woodruff .....	1			
134	16424-091	PIN, Dowel .....	8			
135	17918-091	LOCKWASHER .....	3			
136	19678-045	LOCKWASHER .....	6			
137	25832-041	LOCKWASHER .....	12			
138	30718-044	ELL, Compression .....	2			
139	42603-091	SCREW, Round Head, 6-32 x 7/8 .....	2			



FIG & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
Sheet 3 of 3						
8-4A-						
140	43227-061	PIN, Roll .....	2			
141	43229-061	PIN, Roll .....	1			
142	43240-091	SCREW, Flat Head, 3/8-16 x 3/4 .....	8			
143	43247-091	CONTROL LEVER ASSEMBLY .....	1			
144	43282-091	SETSCREW .....	2			
145	44743-041	SCREW, Cap, 3/8-16 x 5/8 .....	2			
146	44747-042	SCREW, Cap, 3/8-16 x 2 .....	10			
147	46156-061	PIN, Roll .....	4			
148	52729-001	DECAL, Position Indicator .....	1			
149	55123-091	SECTOR, Worm Gear .....	1			
150	55135-056	BEZEL .....	1			
151	55140-001	SHIFTER FORK ASSEMBLY .....	1			
152	55141-091	SUPPORT, Shifter .....	1			
153	55280-045	BRACKET, Mounting .....	1			
154	55364-001	LEVER, Power .....	1			
155	56049-001	SIDE TILT SCREW ASSEMBLY .....	1			
156	74650-045	SCREW, Button Head Socket, 3/8-16 x 5/8 .....	4			
157	75828-091	BEARING, Thrust .....	3			
158	75829-091	RACE, Thrust Bearing .....	6			
159	75870-091	BEARING, Sleeve .....	1			
160	77658-091	SCREW, Shoulder .....	1			
161	77664-061	PIN, Crank .....	1			
162	77671-045	BRACKET AND ROD ASSEMBLY .....	1			
163	77672-042	ROD, Connecting .....	1			
164	77676-091	LEVER ASSEMBLY .....	1			
165	77684-056	SPACER, Bezel .....	1			
166	77685-091	CRANK .....	1			
167	80001-091	SETSCREW, 1/4-20 x 1/2 .....	2			
168	80110-091	BEARING, Needle .....	3			
169	80200-045	BAR, Restraint .....	1			
170	80915-045	NUT, Tensilock .....	1			
171	81596-001	PIN, Support .....	1			
172	*99930-003	SIDE DRIVE ASSEMBLY (See Fig. 8-22) .....	1			
173	133645-010	SADDLE, Side Tilt .....	1			
174	133664-002	COVER, Drive .....	1			
175	133671-002	HANDLE, Select .....	1			
176	133691-001	COPPER TUBE ASSEMBLY .....	1			
177	133692-001	COPPER TUBE ASSEMBLY .....	1			
178	150169-001	MOTOR, Hydraulic (Orbit) .....	1			
 *NOTE: 99930-003 used on units before 1/75. 99930-003 deleted and parts transferred to 134186-001, 134187-001, 134188-001, 134189-001 and 150126-001 on units shipped after 1/75.						

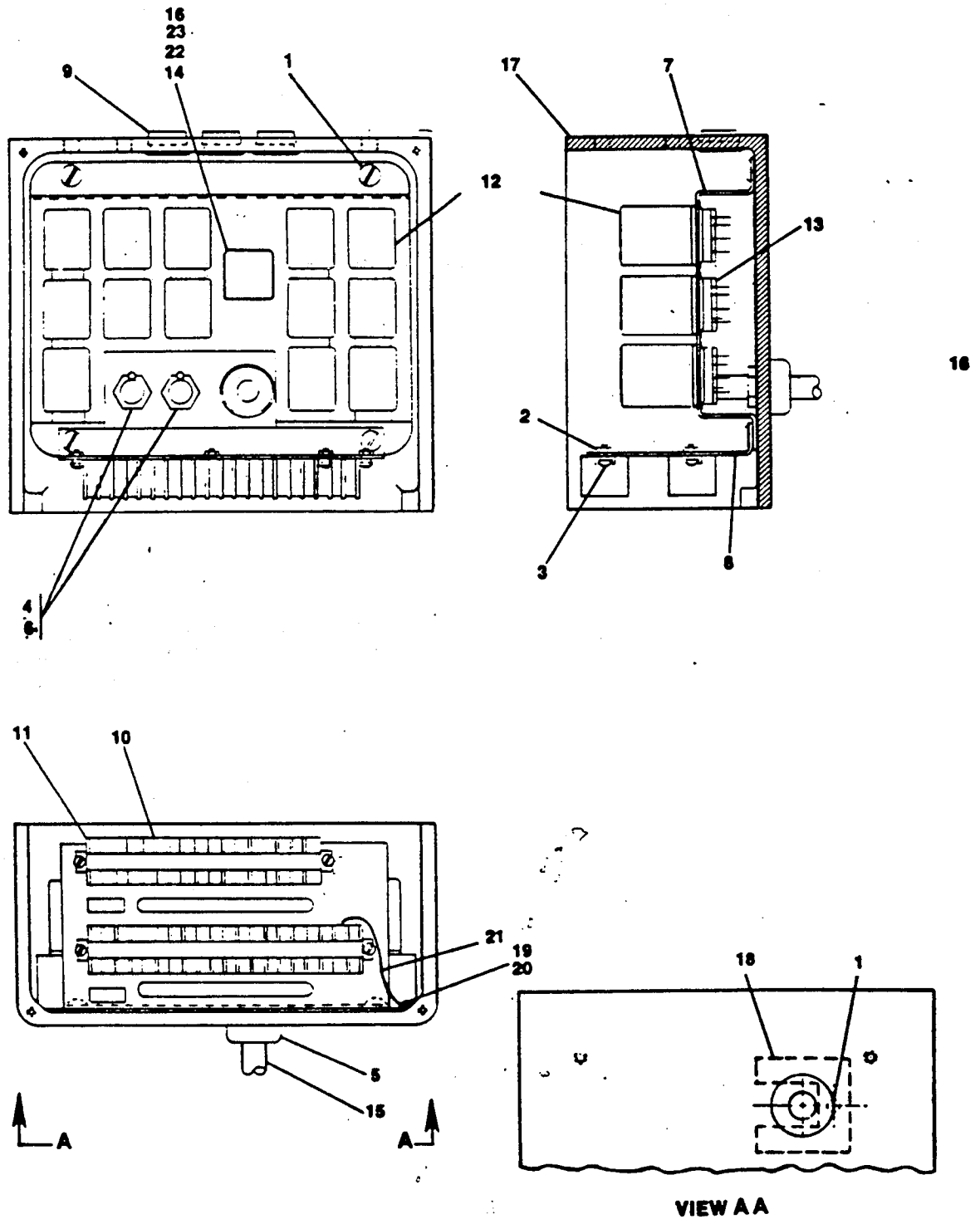


Figure 8-5. 2080RC RELAY BOX ASSEMBLY

FIG & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
8-5-	163521-091	2080RC RELAY BOX ASSEMBLY				
1	9313-091	SCREW, Round Head, 10-32 x 5/16 .....	4			
2	13794-041	NUT, Hex .....	6			
3	17659-041	SCREW, Round Head, 4-40 x 1/4 .....	6			
4	20340-091	HOLDER, Fuse .....	2			
5	30627-091	BUSHING .....	1			
6	33810	FUSE (764317-461) .....	2			
7	55287-091	PLATE, Relay Mounting .....	1			
8	55366-091	PLATE, Terminal Board Mounting .....	1			
9	77798-091	BUSHING .....	4			
10	78047-091	TERMINAL .....	37			
11	78048-091	TERMINAL, End Cap .....	2			
12	80928-091	RELAY .....	13			
13	80929-091	SOCKET, Relay .....	13			
14	150823-079	RECTIFIER .....	1			
15	99048-091	2080RC REMOTE CONTROL BOX ASSEMBLY (See Fig. 8-6) .....	1			
16	118134-091	INSULATION, Sleeve (Not Shown) .....	1			
17	133697-010	BOX, Relay .....	1			
	764317-461	FUSE, 3 Amp (Box of 5) .....	A/R			
18	150823-017	CLIP .....	1			
19	82675-001	SCREW .....	1			
20	76801-045	WASHER .....	1			
21	52724-091	WIRE .....	1			
22	150292-001	SCREW, Rd. Hd., Self Tap .....	1			
23	90695-091	WIRE TERMINAL .....	4			

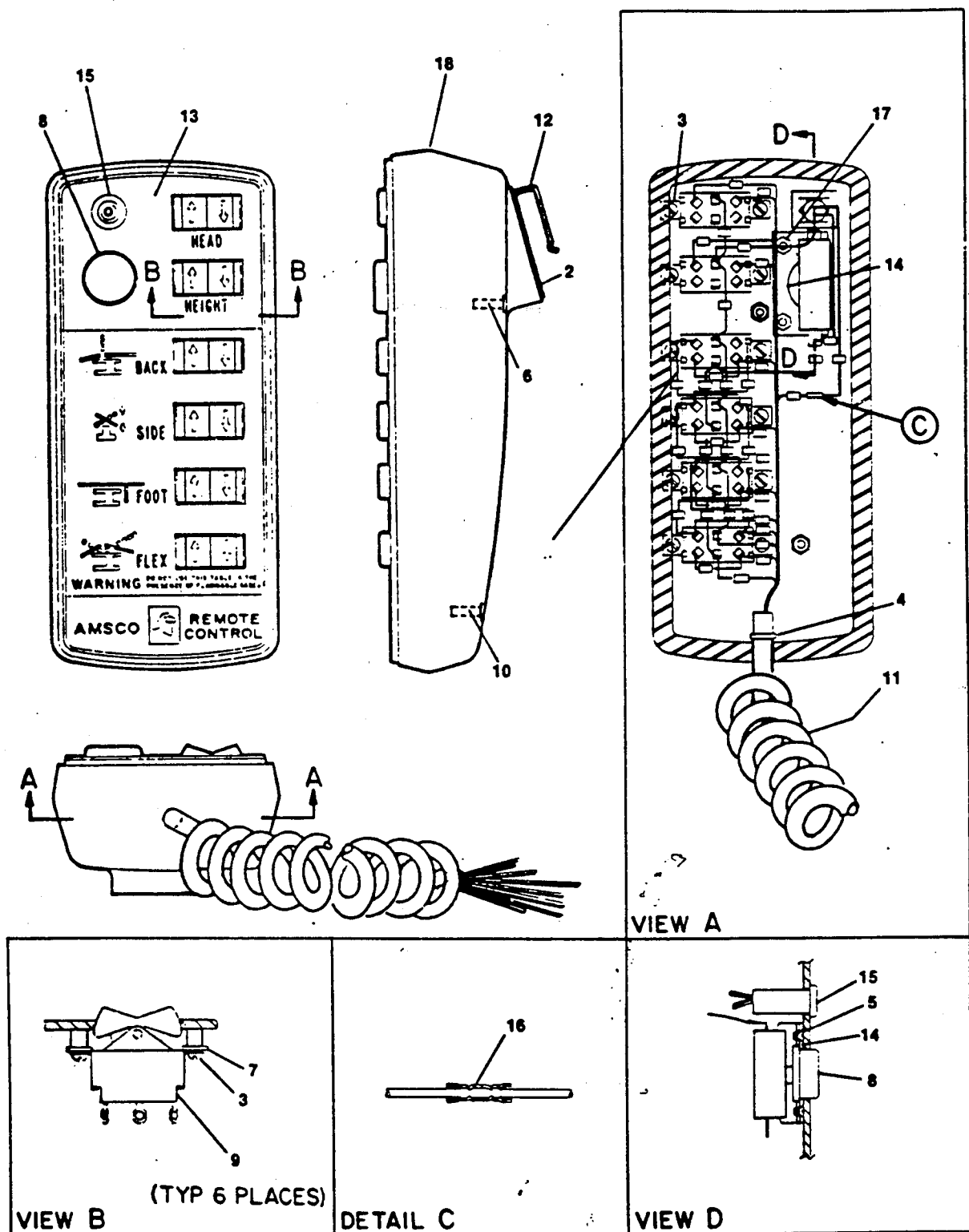


Figure 8-6. 2080RC REMOTE CONTROL BOX

FIG & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
8-6-	99048-091	2080RC REMOTE CONTROL BOX				
1	R-4022-110	WIRE, Solid .....	A/R			
2	4617-041	SCREW, Flat Head, 8-32 x 3/8 .....	3			
3	12451-041	SCREW, Round Head, 6-32 x 1/4 .....	12			
4	13103-001	RELIEF, Strain .....	1			
5	27741-041	SCREW, Flat Head, 6-32 x 3/16 .....	2			
6	38675-041	SCREW, Flat Head, 10-32 x 1-3/4 .....	1			
7	42460-091	WASHER .....	12			
8	47788-091	SWITCH .....	1			
9	52683-091	SWITCH .....	6			
10	55281-004	SCREW, Flat Head, 10-32 x 1-1/2 .....	1			
11	55294-091	CORD, Coiled (See Fig. 8-29) .....	1			
12	55295-061	CLIP, Control Box .....	1			
13	56221-001	COVER ASSEMBLY .....	1			
14	80907-091	PLATE, Switch Mounting .....	1			
15	80934-091	LIGHT, Pilot .....	1			
16	80981-091	CONNECTOR, Butt .....	1			
17	118439-045	LOCKNUT .....	2			
18	133693-010	BOX, Control .....	1			

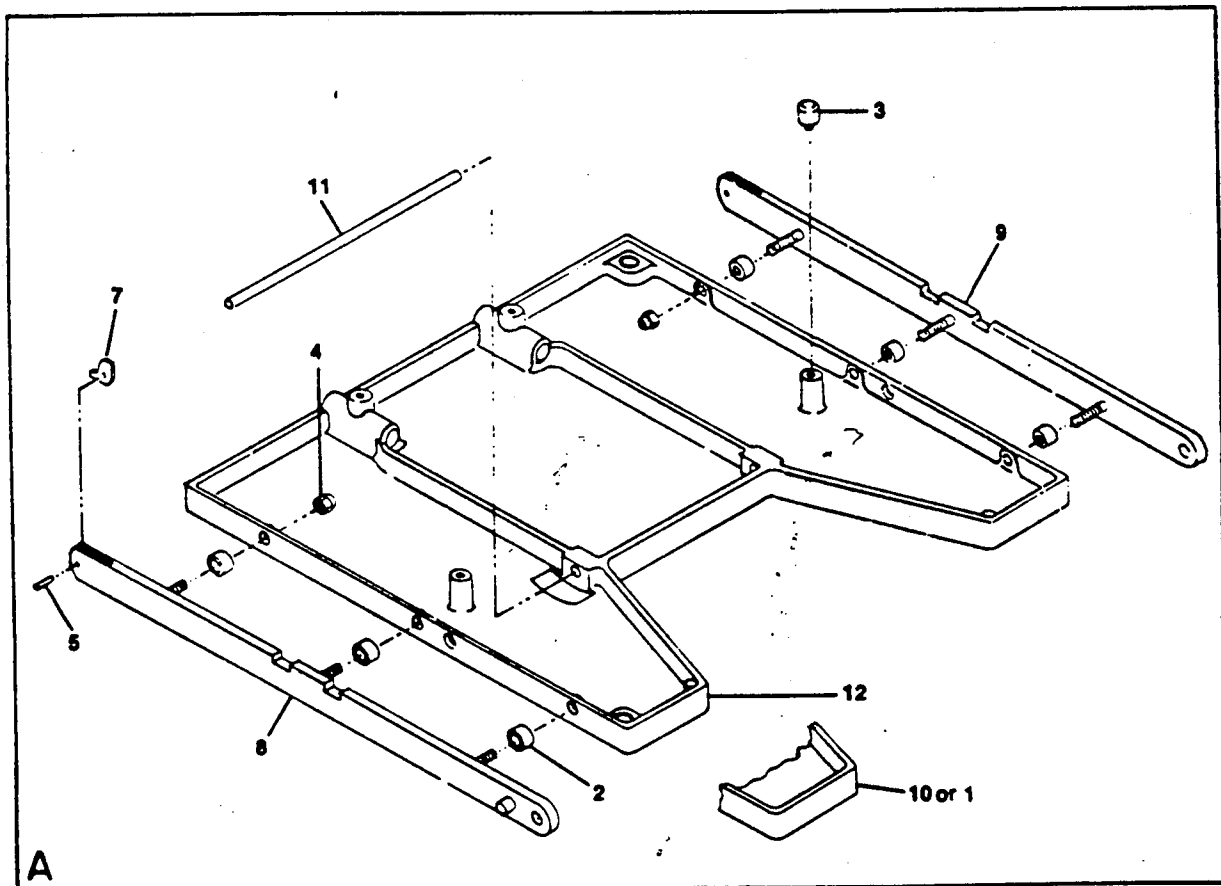
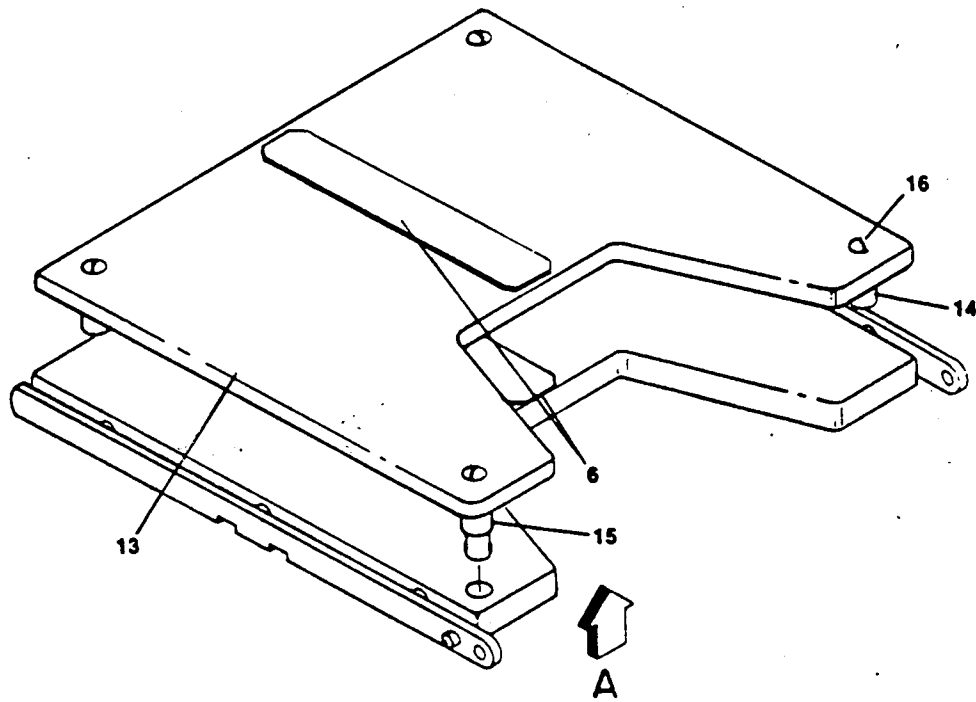


Figure 8-7. LEG SECTION ASSEMBLY

FIG & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY
8-7-	55104-091	LEG SECTION ASSEMBLY	
1	R-5300-113	ADHESIVE, Plibond (Goodyear) .....	A/R
2	15171-042	SPACER .....	6
3	19013-091	BUMPER, Rubber .....	2
4	27184-045	NUT, Hug Lock, 5/16-18 .....	6
5	43224-061	PIN, Roll .....	2
6	43415-091	FASTENER, Hook (Velcro) .....	1
7	51112-061	CAM .....	1
8	75705-063	RAIL, Side, R.H. ....	1
9	75706-063	RAIL, Side, L.H. ....	1
10	77564-063	LEG SECTION COVER ASSEMBLY .....	1
11	77565-061	ROD, Hinge .....	1
12	133643-010	CASTING, Leg Section .....	1
	55126-001	X-RAY TOP ASSEMBLY, LEG SECTION (755715-170)	
6	43415-091	• FASTENER, Hook (Velcro) .....	1
13	56397-069	• TOP, X-ray .....	1
14	77643-056	• SPACER .....	2
15	92475-001	• SPACER ASSEMBLY .....	2
16	150055-001	• SCREW, Truss Head .....	4

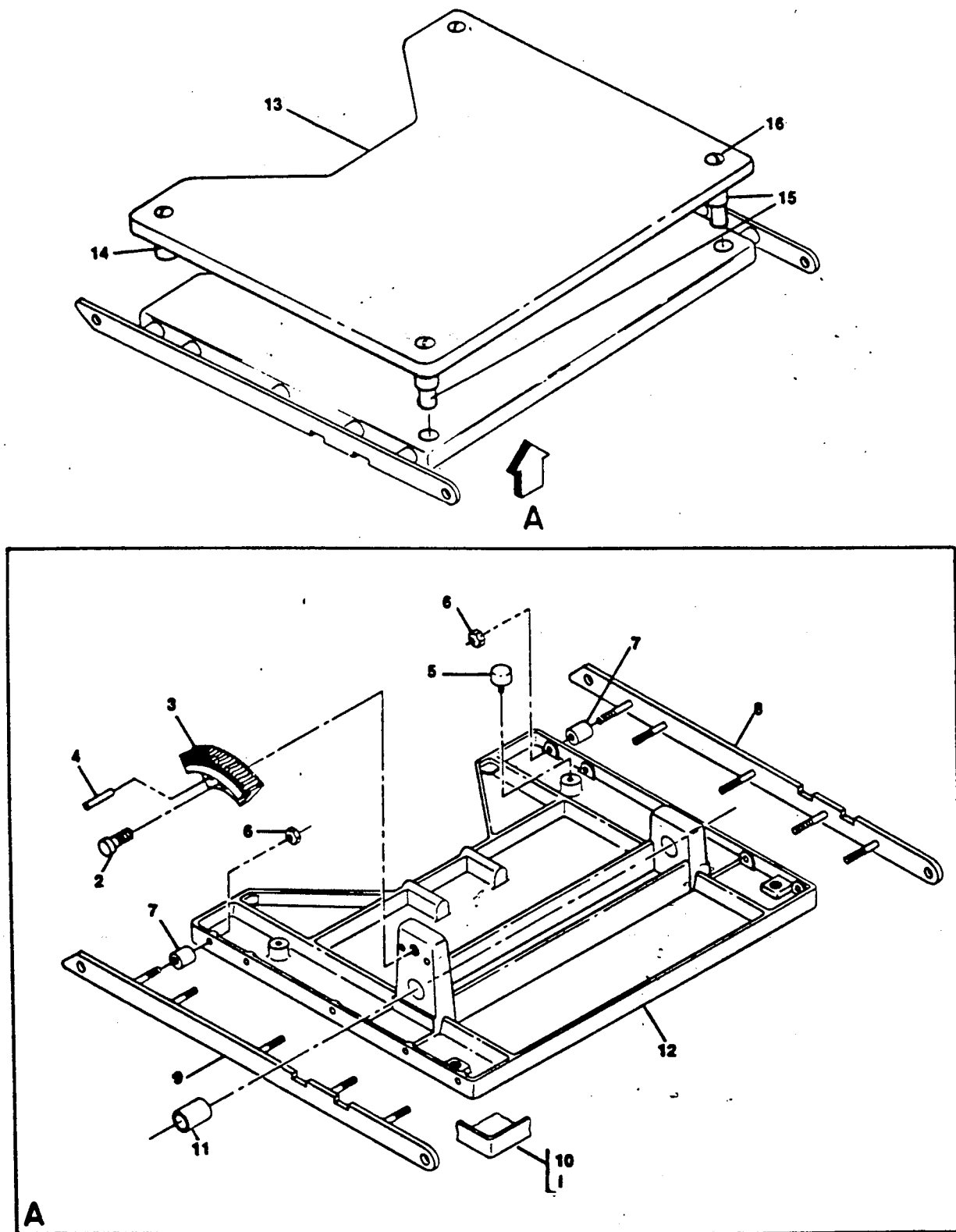
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Figure 8-8. SEAT SECTION ASSEMBLY



FIG & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
8-8	55100-091	SEAT SECTION ASSEMBLY				
1	R-5300-113	ADHESIVE, Pliobond (Goodyear) .....	A/R	1		
2	15335-041	SCREW, Socket Head, 1/2-13 x 1 .....		1		
3	16290-091	SECTOR, Worm .....		1		
4	16836-041	PIN .....		2		
5	19013-091	BUMPER, Rubber .....		2		
6	27184-045	NUT, Hug Lock, 5/16-18 .....		10		
7	43325-042	SPACER .....		10		
8	45000-063	RAIL, Side, L.H. ....		1		
9	45002-063	RAIL, Side, R.H. ....		1		
10	77563-063	SEAT SECTION COVER ASSEMBLY .....		1		
11	78304-091	BEARING, Sleeve .....		2		
12	133644-010	CASTING, Seat Section .....		1		
	55127-001	X-RAY TOP ASSEMBLY, SEAT SECTION (755715-227)				
13	56397-068	• TOP, X-ray .....		1		
14	77643-056	• SPACER .....		2		
15	92475-001	• SPACER ASSEMBLY .....		2		
16	150055-001	• SCREW, Truss Head .....		4		

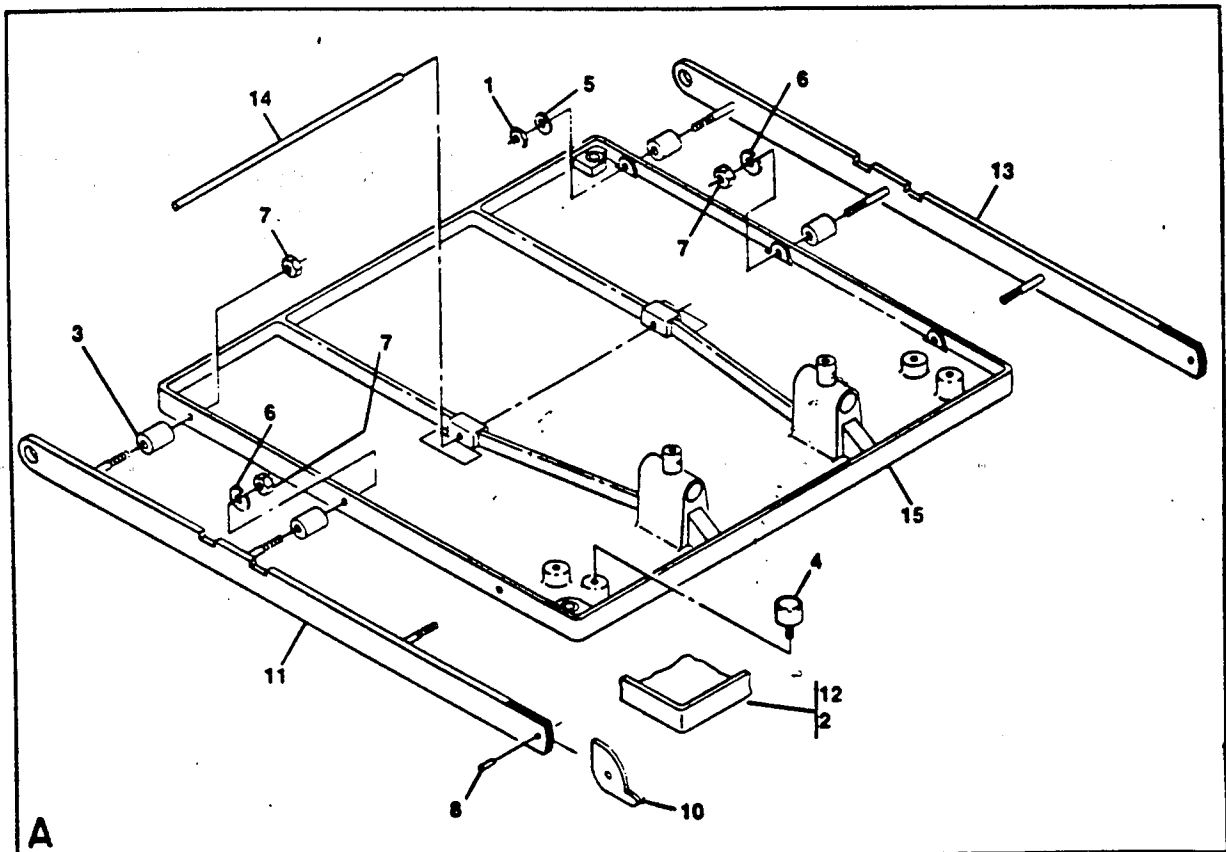
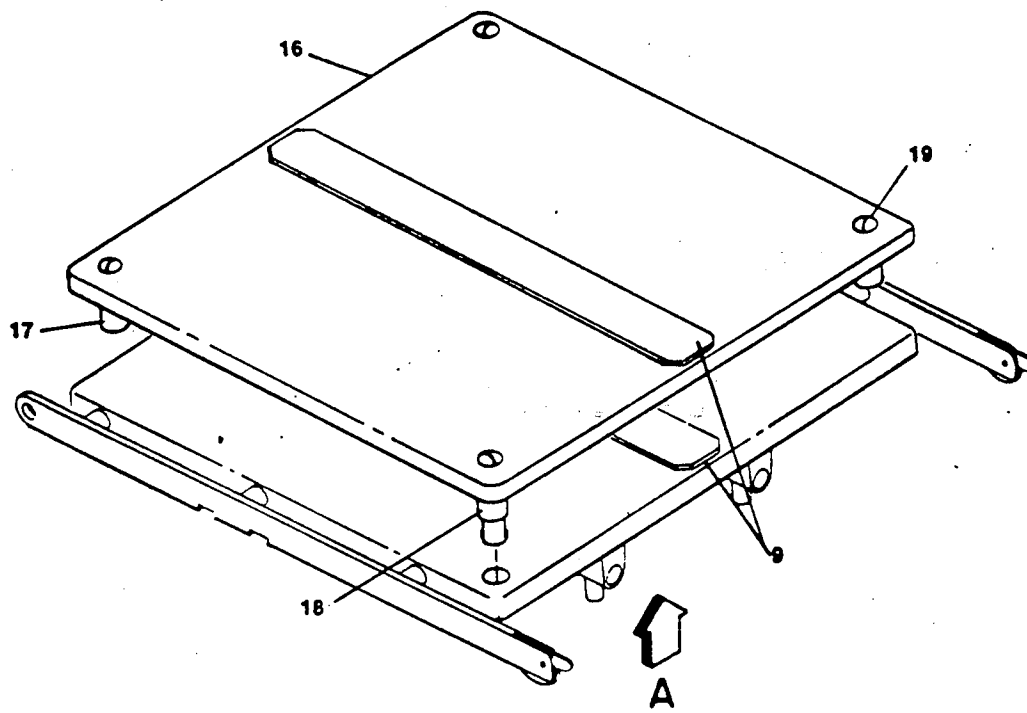


Figure 8-9. BACK SECTION ASSEMBLY



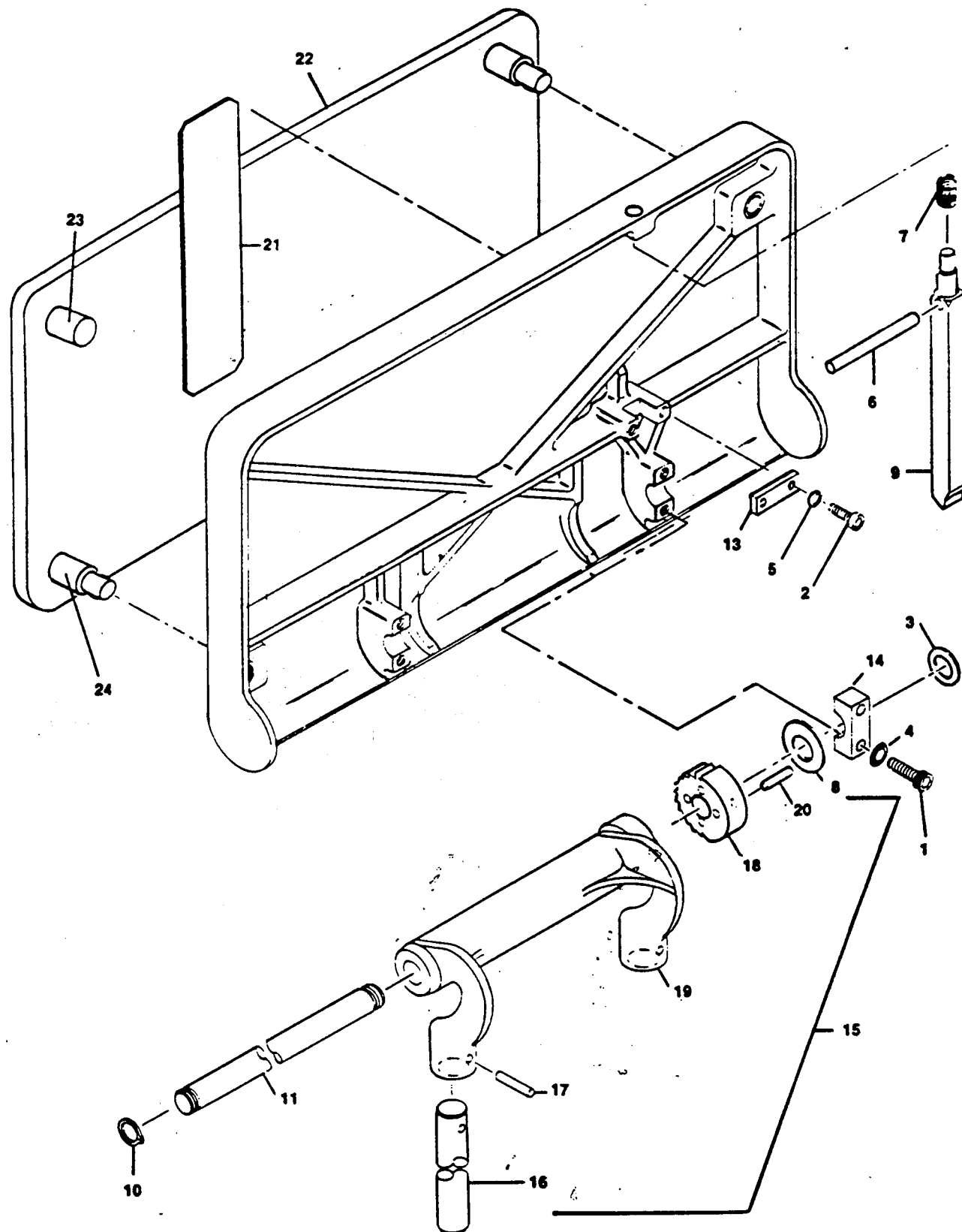


Figure 8-10. HEADREST ASSEMBLY.

Service Bulletin Number						
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FIG. & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
8-10-	133688-001	HEADREST ASSEMBLY				
1	11266-045	SCREW, Soc. HD. Cap, 1/4-20 x 1" LG., Steel .....	4			
2	16451	SCREW, Soc. HD. Cap, 10-32 x 1/2 Nylock, Steel (Sub: 41012-061) .....	2			
3	17285-045	WASHER, Special .....	1			
4	19678-045	LOCKWASHER, 1/4, Steel .....	4			
5	19685-061	LOCKWASHER, 10, Stainless Steel .....	2			
6	26016-061	PIN, Grooved, 1/4 x 3" LG., ASA Type "E," Stainless Steel .....	1			
7	26017-061	SPRING, Compression, Stainless Steel .....	1			
8	42728-042	WASHER, 11/16 I.D. x 1-3/8 O.D. x 1/4 Thickness, Brass .....	1			
9	42729-045	RATCHET LEVER .....	1			
10	42730-045	RETAINING RING, Waldes Truarc, 5103-62 .....	2			
11	42732-091	ROD, Hinge .....	1			
12	43412-091	HOOK FASTENER .....	1			
13	77640	CAP (Sub: 150823-035) .....	1			
14	78777-002	BEARING CAP .....	2			
NOTE 1	N.L.A. (99328)	HEADREST .....	1			
15	55358-091	SHAFT AND SUPPORT ASSEMBLY				
16	16164-044	• SHAFT .....	2			
17	29479-061	• PIN, Grooved, 3/16 x 1-1/8 LG., ASA Type "C", Stainless Steel .....	2			
18	42727-042	• RATCHET .....	1			
19	42733-001	• SUPPORT .....	1			
20	43229-061	• PIN, Roll, 3/16 Dia x 1" LG., Stainless Steel .....	4			
	55124	X-RAY TOP ASSEMBLY, HEAD SECTION (Sub: 755715-168)				
12	43412-091	• HOOK FASTENER .....	1			
22	56397-067	• TOP, X-ray .....	1			
23	77643-056	• SPACER .....	2			
24	92475-001	• SPACER ASSEMBLY .....	2			
25	150055-001	• SCREW, Truss Head .....	4			
NOTE 1: Order 133688-001 for headrest 99328.						

Service Bulletin Number						
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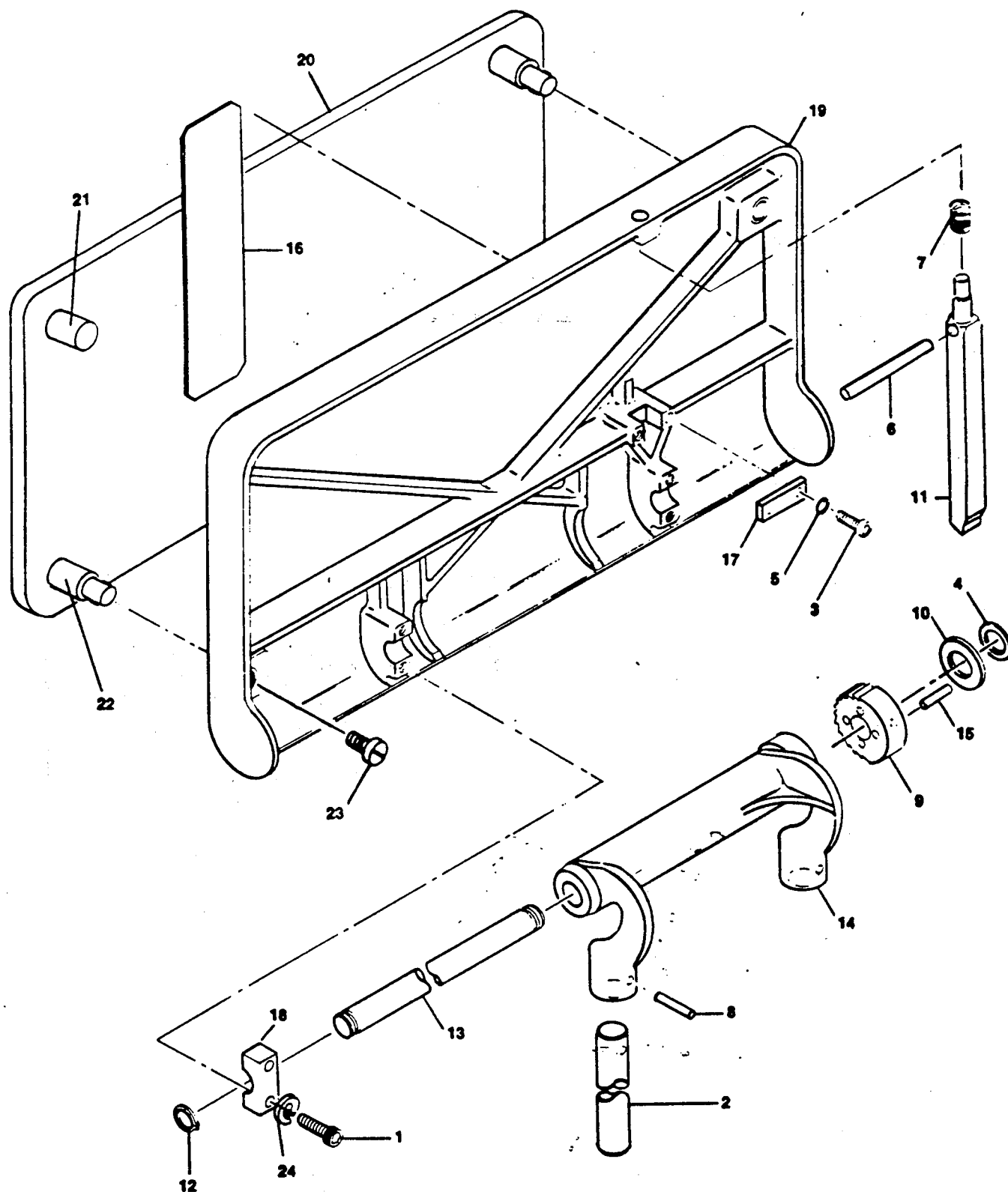
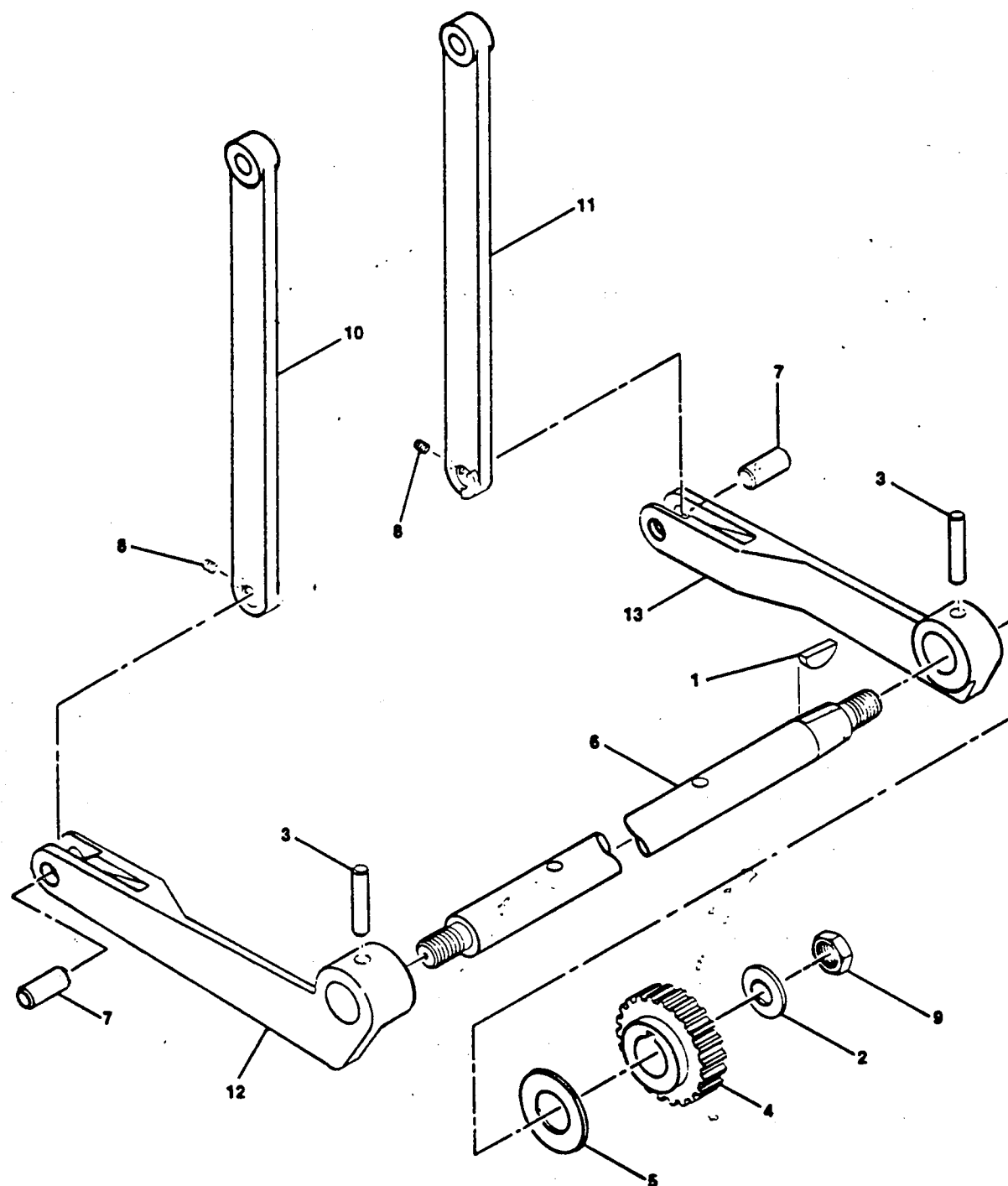


Figure 8-11. 2080L, 2080RC &amp; COMPAT IV HEADREST ASSEMBLY.

FIG & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
8-11-	133688-001	2080L, 2080RC, 2080 COMPAT IV HEADREST ASSEMBLY				
1	11266-045	SCREW, Socket Head, 1/4-20 x 1 .....	4			
2	55358-091	SHAFT AND SUPPORT ASSEMBLY (Includes Items 8, 9, 14 and 15) .....	1			
	16164-044	• SHAFT .....	2			
3	41012-061	SCREW, Socket Head Cap, 10-32 x 1/2 .....	2			
4	17285-045	WASHER .....	1			
5	19685-061	LOCKWASHER .....	2			
6	26016-061	PIN, Groove .....	1			
7	26017-061	SPRING, Compression .....	1			
8	29479-061	PIN, Groove .....	2			
9	42727-042	RATCHET .....	1			
10	42728-042	WASHER .....	1			
11	42729-045	LEVER, Ratchet .....	1			
12	42730-045	RING, Retaining .....	2			
13	42732-091	ROD, Hinge .....	1			
14	42733-001	SUPPORT .....	1			
15	43229-061	PIN, Roll .....	4			
16	43412-091	FASTENER, Hook (Velcro) .....	1			
17	77640-002	CAP .....	1			
18	78777-002	CAP, Bearing .....	2			
19	99328-010	HEADREST .....	1			
24	19678-045	LOCKWASHER, 1/4 .....	4			
	55124-001	X-RAY TOP ASSEMBLY, HEAD SECTION (755715-168)				
16	43412-091	• FASTENER, Hook (Velcro) .....	1			
20	56397-067	• TOP, X-ray .....	1			
21	77643-056	• SPACER .....	2			
22	92475-001	• SPACER ASSEMBLY .....	2			
23	150055-091	• SCREW, Truss Head .....	4			

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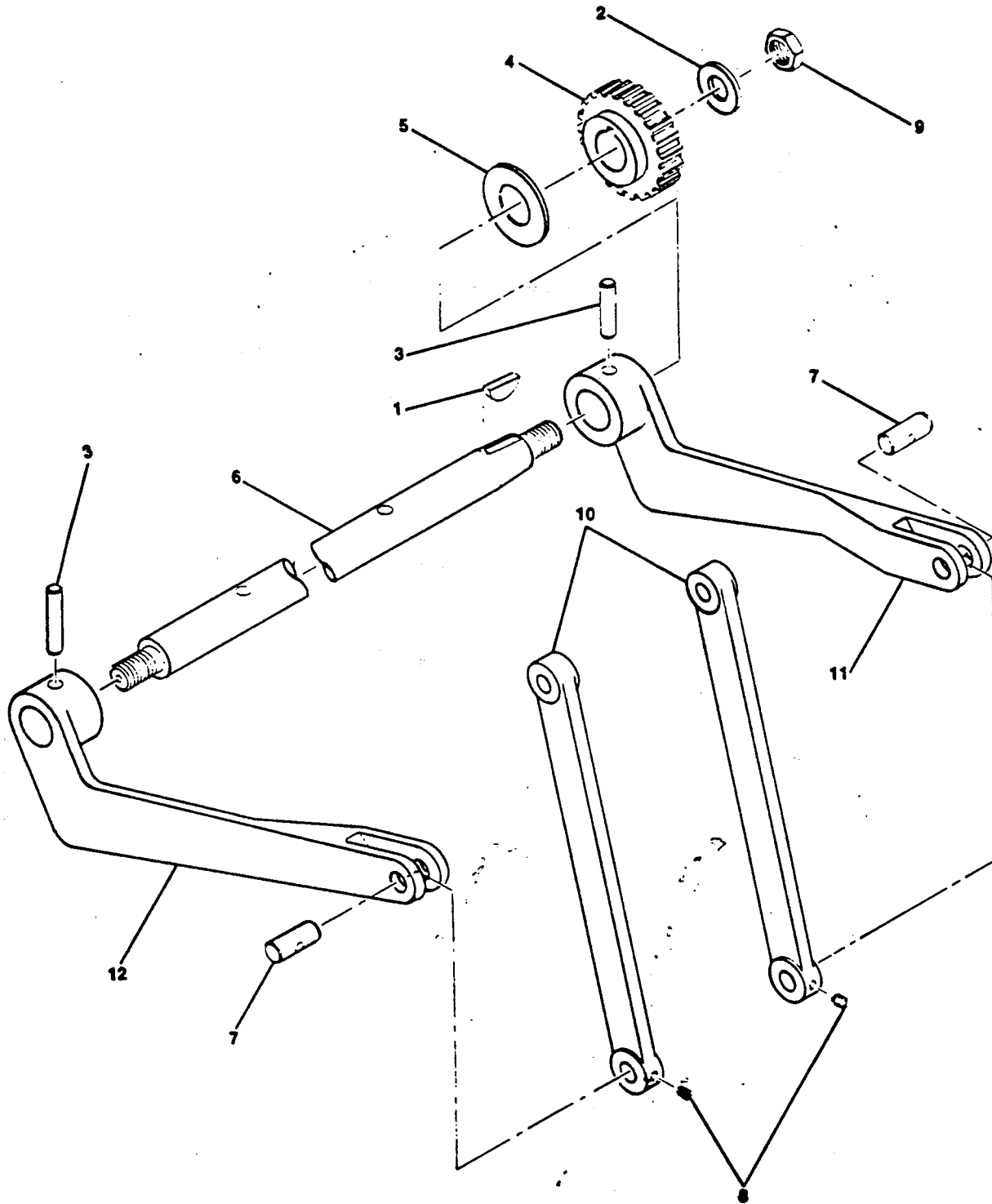


**Figure 8-12. LEG SECTION LEVER ARM ASSEMBLY**



FIG & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
8-12-	55114-002	LEG SECTION LEVER ARM ASSEMBLY				
1	8301-091	KEY, Woodruff .....	1			
2	15014-091	WASHER .....	1			
3	15300-041	PIN, Taper .....	2			
4	16108-091	GEAR, Worm .....	1			
5	16201-091	WASHER, Oilite .....	1			
6	16218-061	SHAFT .....	1			
7	16266-063	PIN .....	2			
8	16918-041	SETSCREW, 10-32 x 3/8 .....	2			
9	26028-091	NUT, Elastic Stop .....	1			
10	55097-010	ARM, Lever, L.H. ....	1			
11	55098-010	ARM, Lever, R.H. ....	1			
12	133640-010	ARM, Lever, L.H. ....	1			
13	133641-010	ARM, Lever, R.H. ....	1			

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**Figure 8-13. BACK SECTION LEVER ARM ASSEMBLY**

FIG & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
8-13-	55114-001	BACK SECTION LEVER ARM ASSEMBLY				
1	8301-091	KEY, Woodruff .....	1			
2	15014-091	WASHER .....	1			
3	15300-041	FIN, Taper .....	2			
4	16106-091	GEAR, Worm .....	1			
5	16201-091	WASHER, Oilite .....	1			
6	16218-061	SHAFT .....	1			
7	16266-063	PIN .....	2			
8	16918-041	SETSCREW .....	2			
9	26028-091	NUT, Elastic Stop .....	1			
10	55099-010	ARM, Lever .....	2			
11	133639-010	ARM, Lever, R.H. ....	1			
12	133642-010	ARM, Lever, L.H. ....	1			

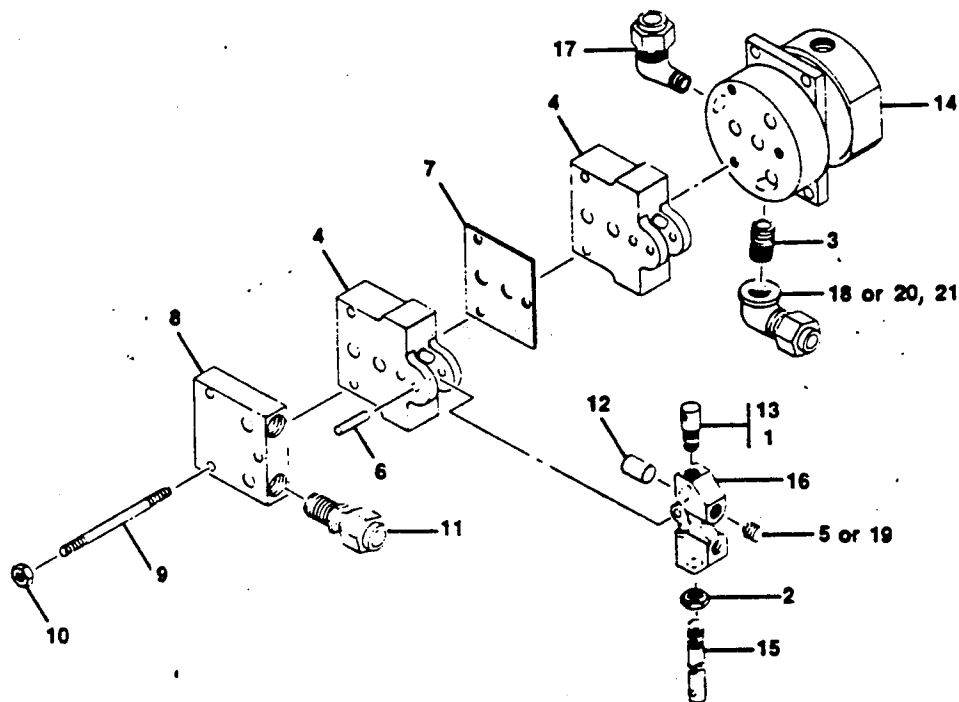


Figure 8-14. 2080RC VALVE ASSEMBLY

FIG & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
8-14-	55150-091	2080RC VALVE ASSEMBLY (Units Shipped Before 6/80) .....	X			
		2080RC VALVE ASSEMBLY (Units Shipped After 6/80) .....		X		
1	R-5300-548	LOCTITE, Stud Lock .....	A/R	A/R		
2	24987-041	NUT, Jam .....	2	2		
3	33816-043	NIPPLE, Close .....	1	1		
4	42563	VALVE, Gabriel (Sub. 134469-008) .....	2	2		
5	42629-045	SETSCREW .....	4	-		
6	43238-061	PIN, Roll .....	2	2		
7	43284-091	PLATE, Separator .....	1	1		
8	43285-091	PLATE, End .....	1	1		
9	43286-091	STUD .....	3	3		
10	43287-091	NUT, Hex .....	3	3		
11	43289-091	FITTING, Compression .....	2	2		
12	44603-061	PLUG, Actuator .....	4	4		
13	52725-061	STUD, Shoulder .....	2	2		
14	55148-010	MANIFOLD .....	1	1		
15	77634-045	ROD, Connecting .....	2	2		
16	78199-001	LEVER, Valve .....	2	2		
17	78317-091	ELBOW, Male .....	1	1		
18	78318-091	ELBOW, Female .....	1	-		
19	150823-002	SCREW, Adjusting .....		4		
20	1614-091	ELBOW, Female .....		1		
21	80918-091	CONNECTOR, Male .....		1		

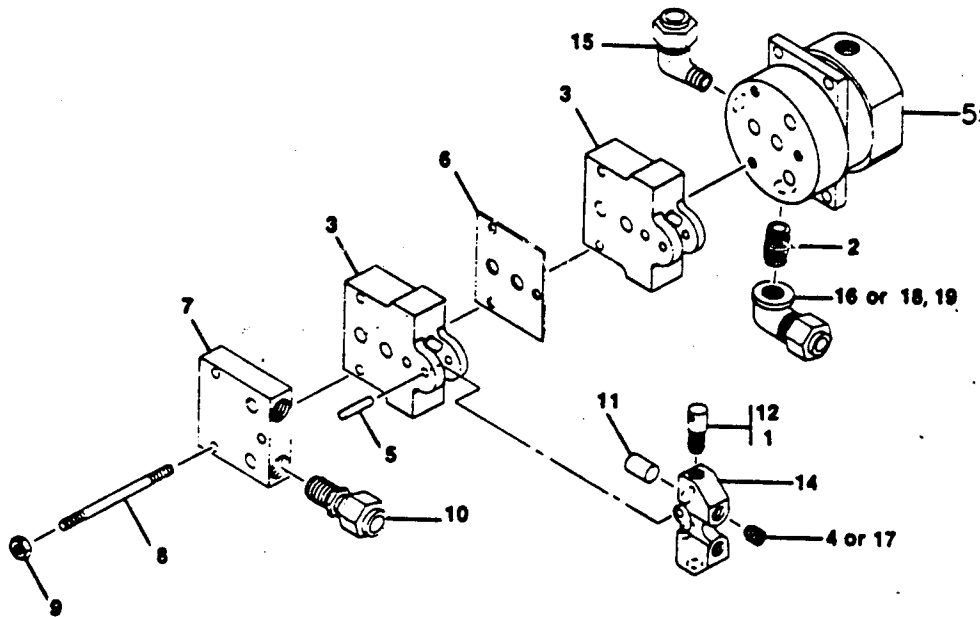
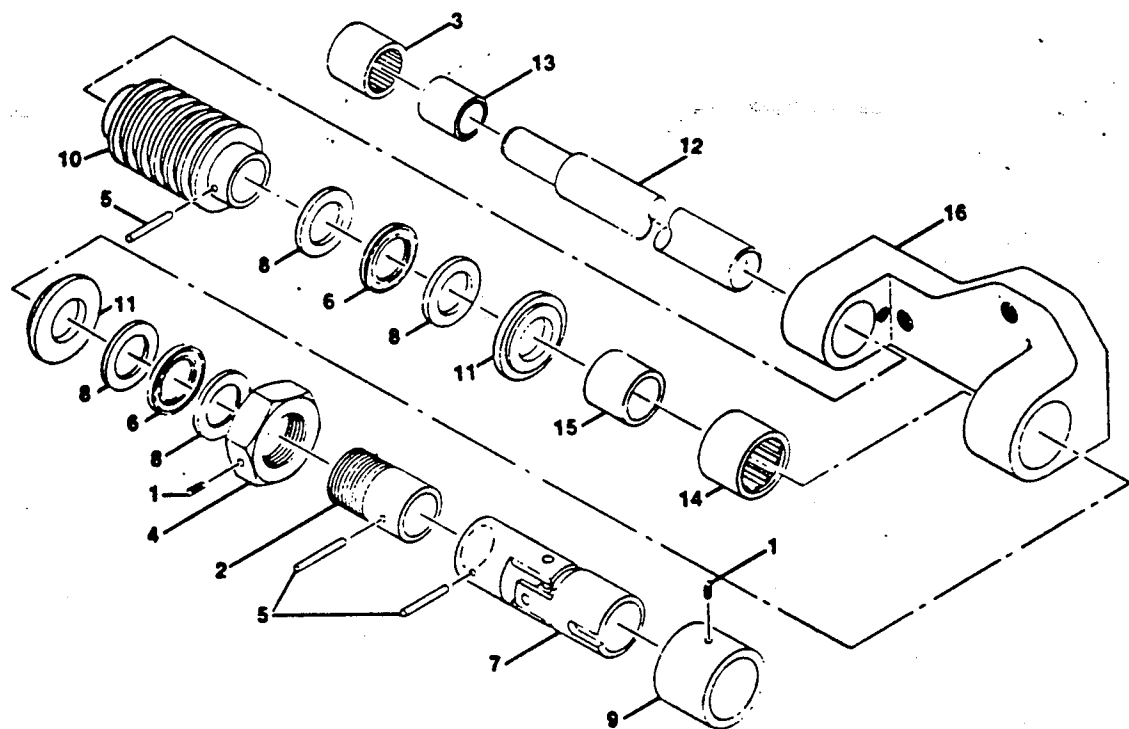


Figure 8-15. 2080L AND 2080 COMPAT VALVE ASSEMBLY

FIG & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
8-15-	55149-091	2080L AND 2080 COMPAT VALVE ASSEMBLY (Units Shipped Before 1/81) .....	X			
		2080L AND 2080 COMPAT VALVE ASSEMBLY (Units Shipped After 1/81) .....		X		
1	R-5300-548	LOCTITE, Stud Lock .....	A/R	A/R		
2	33816-043	NIPPLE, Close .....	1	1		
3	42563	VALVE, Gabriel (Sub. 134469-008) .....	2	2		
4	42629-045	SETSCREW .....	4	-		
5	43238-061	PIN, Roll .....	2	2		
6	43284-091	PLATE, Separator .....	1	1		
7	43285-091	PLATE, End .....	1	1		
8	43286-091	STUD .....	3	3		
9	43287-091	NUT, Hex .....	3	3		
10	43289-091	FITTING, Compression .....	2	2		
11	44603-061	PLUG, Actuator .....	4	4		
12	52725-061	STUD, Shoulder .....	2	2		
13	55148-010	MANIFOLD .....	1	1		
14	78199-001	LEVER, Valve .....	2	2		
15	78317-091	ELBOW, Male .....	1	1		
16	78318-091	ELBOW, Female .....	1	-		
17	150823-002	SCREW, Adjusting .....		4		
18	1614-091	ELBOW, Female .....		1		
19	80918-091	CONNECTOR, Male .....		1		



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**Figure 8-16. TRENDLENBURG SHAFT AND BEARING ASSEMBLY.**

FIG & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
8-16	133676-001	TRENDELENBURG SHAFT AND BEARING ASSEMBLY				
1	4772-045	SETSCREW .....	2			
2	16179-091	SLEEVE .....	1			
3	16182-091	BEARING, Needle .....	1			
4	16189-091	NUT .....	1			
5	16273-041	PIN, Taper .....	4			
6	75828-091	BEARING, Needle .....	2			
7	76543-091	JOING, Universal .....	1			
8	76549-091	RACE, Bearing .....	4			
9	76614-045	SLEEVE .....	1			
10	77639-091	GEAR, Worm .....	1			
11	80187-061	SPACER .....	2			
12	80188-091	SHAFT, Trendelenburg .....	1			
13	80189-091	RACE, Inner .....	1			
14	80190-091	BEARING, Needle .....	1			
15	80191-091	RACE, Inner .....	1			
16	133696-091	PLATE, Mounting .....	1			

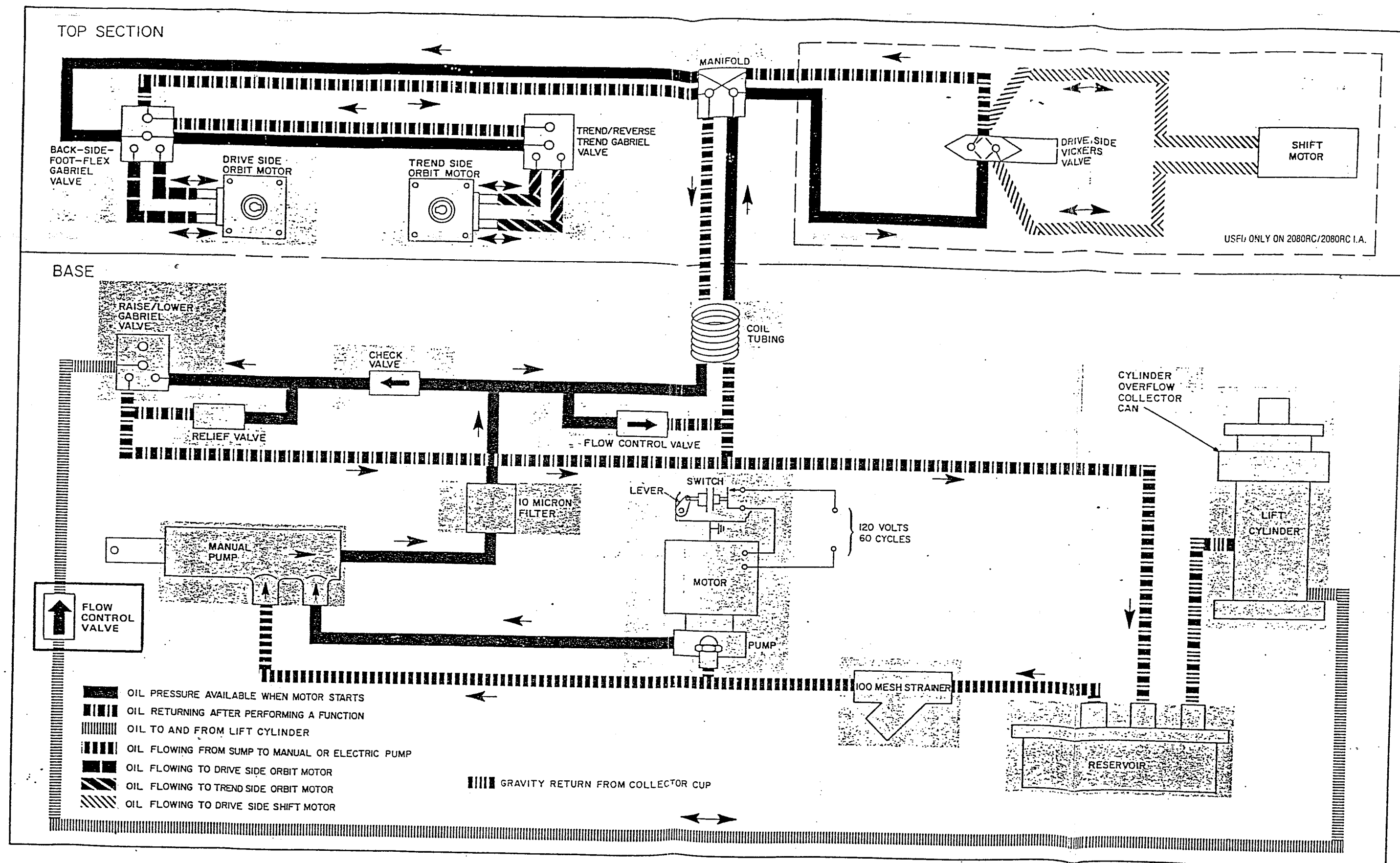


Figure 4-1. 2080L/2080RC/2080RC I.A.  
HYDRAULIC BLOCKED SCHEMATIC DIAGRAM.



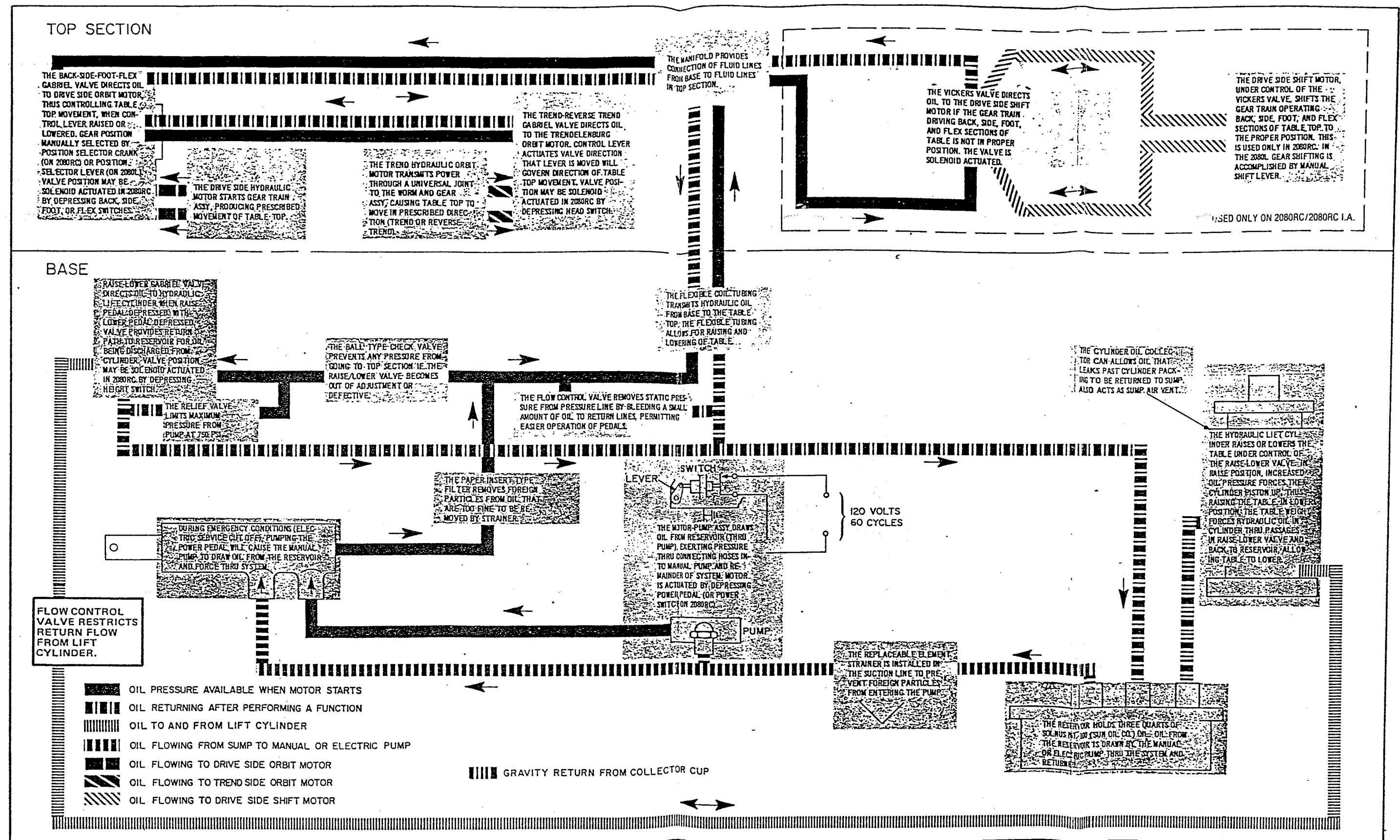


Figure 4-2. 2080L/2080RC/2080RC I.A.  
HYDRAULIC BLOCKED TEXT DIAGRAM.

120 VAC, 60 CPS SINGLE PHASE POWER SUPPLY

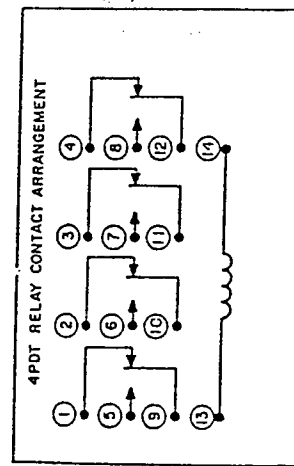
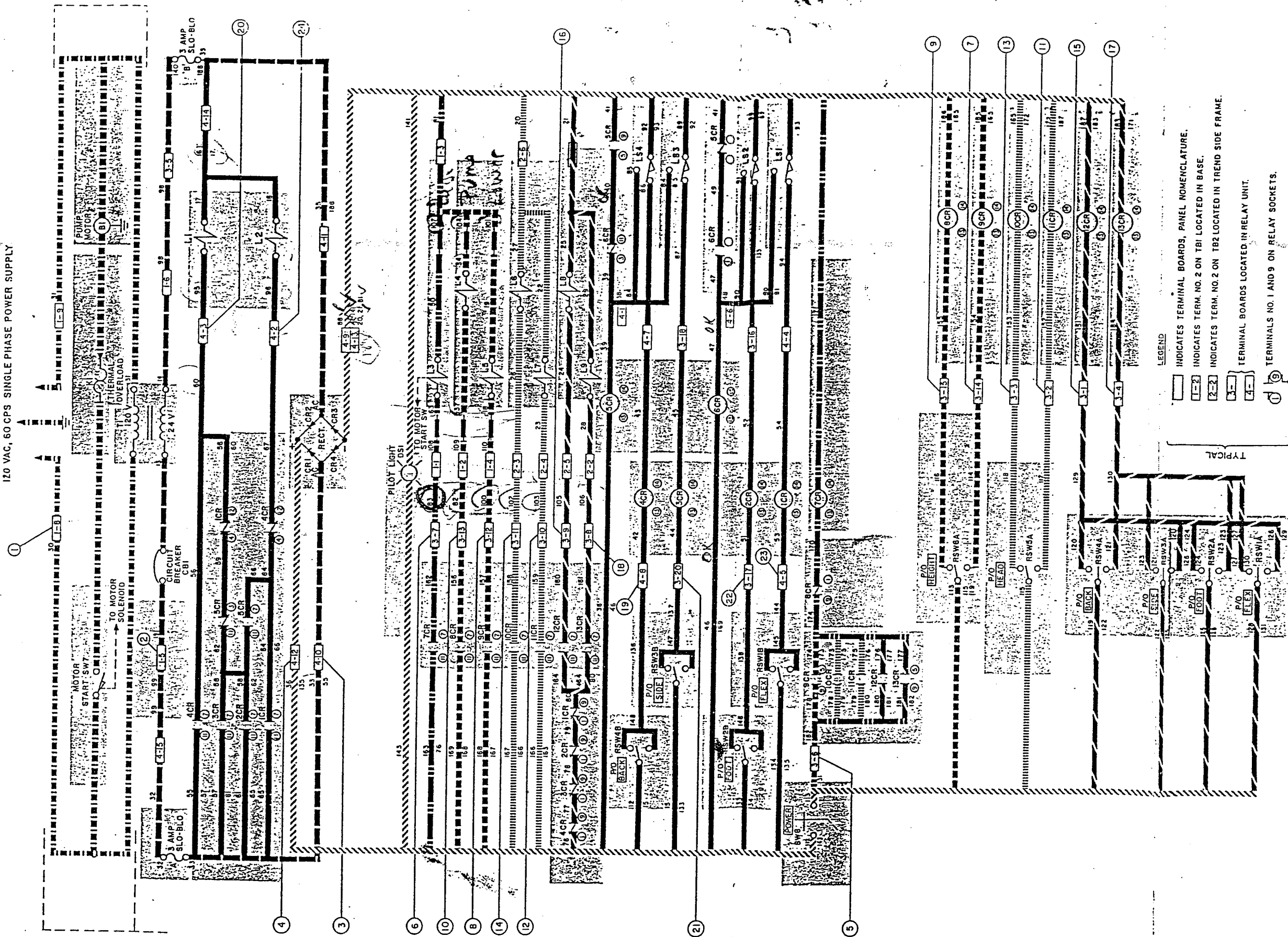
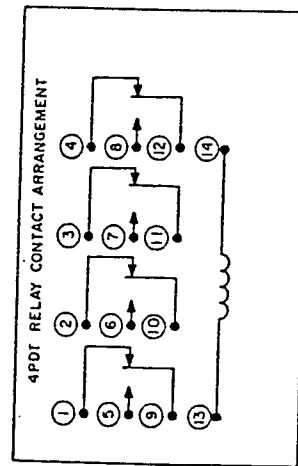


Figure 5-1. 2080RC/2080RC I.A.  
ELECTRICAL BLOCKED SCHEMATIC DIAGRAM.



5-5/5-6

TABLE G-2. MAINTENANCE DEPENDENCY CHART

CHECKOUT PROCEDURE	<div> <div>TB1-8/9</div> <div>TB1-5/6</div> <div>FUSE F1</div> <div>FUSE F2</div> <div>CKT BKR CB1</div> <div>TB4-10/11</div> <div>TB4-12/9</div> <div>PILOT LIGHT DS1</div> <div>TB3-6/TB4-9</div> <div>TB3-7/TB4-9</div> <div>PUMP SOL L3</div> <div>MOTOR SWITCH L3</div> <div>THERM OVRD SW 7</div> <div>MOTOR-PUMP KI</div> <div>TB3-14/TB4-9</div> <div>TB3-12/TB4-9</div> <div>RAISE SOL L5</div> <div>TB3-15/TB4-9</div> <div>TB3-13/TB4-9</div> <div>LOWER SOL L4</div> <div>TB3-2/TB4-9</div> <div>TB3-10/TB4-9</div> <div>HEAD UP SOL L7</div> <div>TB3-3/TB4-9</div> <div>HEAD DOWN SOL L6</div> <div>TB3-11/TB4-9</div> <div>TB3-1/TB4-9</div> <div>TOP UP SOL L8</div> <div>TB3-4/TB4-9</div> <div>TOP DOWN SOL L9</div> <div>TB4-8/9</div> <div>REVERSE SOL L9</div> <div>TB3-20/TB4-9</div> <div>TB3-17/TB4-9</div> <div>TB4-5/9</div> <div>TB4-2/9</div> <div>FORWARD SOL L2</div> </div>																							
	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24
1. OBSERVE THAT PILOT LIGHT ON REMOTE CONTROL BOX LIGHTS (POWER CORD MUST BE PLUGGED INTO SOURCE OF 115 VAC, 60 HZ)	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
2. ALTERNATELY DEPRESS REMOTE CONTROL BOX ROCKER SWITCHES TO ACTUATE PUMP-MOTOR; [POWER] SWITCH SHOULD SIMULTANEOUSLY BE DEPRESSED. (IF PUMP-MOTOR OPERATES IN ANY MODE, CONTINUE WITH STEP 3)					▲	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
3. PUSH AND HOLD [HEIGHT] SWITCH IN RAISE (↑) POSITION; SIMULTANEOUSLY HOLD [POWER] SWITCH DEPRESSED							▲	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
4. PUSH AND HOLD [HEIGHT] SWITCH IN LOWER (↓) POSITION; SIMULTANEOUSLY HOLD [POWER] SWITCH DEPRESSED							▲	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
5. PUSH AND HOLD [HEAD] SWITCH IN UP (↑) POSITION; SIMULTANEOUSLY HOLD [POWER] SWITCH DEPRESSED							▲	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
6. PUSH AND HOLD [HEAD] SWITCH IN DOWN (↓) POSITION; SIMULTANEOUSLY HOLD [POWER] SWITCH DEPRESSED							▲	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
7. PUSH AND HOLD [FLEX] SWITCH IN UP (↑) POSITION; SIMULTANEOUSLY HOLD [POWER] SWITCH DEPRESSED							▲	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
8. PUSH AND HOLD [FLEX] SWITCH IN DOWN (↓) POSITION; SIMULTANEOUSLY HOLD [POWER] SWITCH DEPRESSED							▲	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
9. WHILE OBSERVING REVERSE SELECTOR SOLENOID L1, PUSH AND HOLD [BACK] SWITCH IN UP (↑) POSITION; SIMULTANEOUSLY HOLD [POWER] SWITCH DEPRESSED							▲	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
10. WHILE OBSERVING FORWARD SELECTOR SOLENOID L2, PUSH AND HOLD [SIDE] SWITCH IN UP (↑) POSITION; SIMULTANEOUSLY HOLD [POWER] SWITCH DEPRESSED							▲	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
11. WHILE OBSERVING FORWARD SELECTOR SOLENOID L2, PUSH AND HOLD [FOOT] SWITCH IN UP (↑) POSITION; SIMULTANEOUSLY HOLD [POWER] SWITCH DEPRESSED							▲	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
12. WHILE OBSERVING FORWARD SELECTOR SOLENOID L2, PUSH AND HOLD [FLEX] SWITCH IN UP (↑) POSITION; SIMULTANEOUSLY HOLD [POWER] SWITCH DEPRESSED							▲	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●

TABLE 6-1. TROUBLESHOOTING CHART (PART 1)

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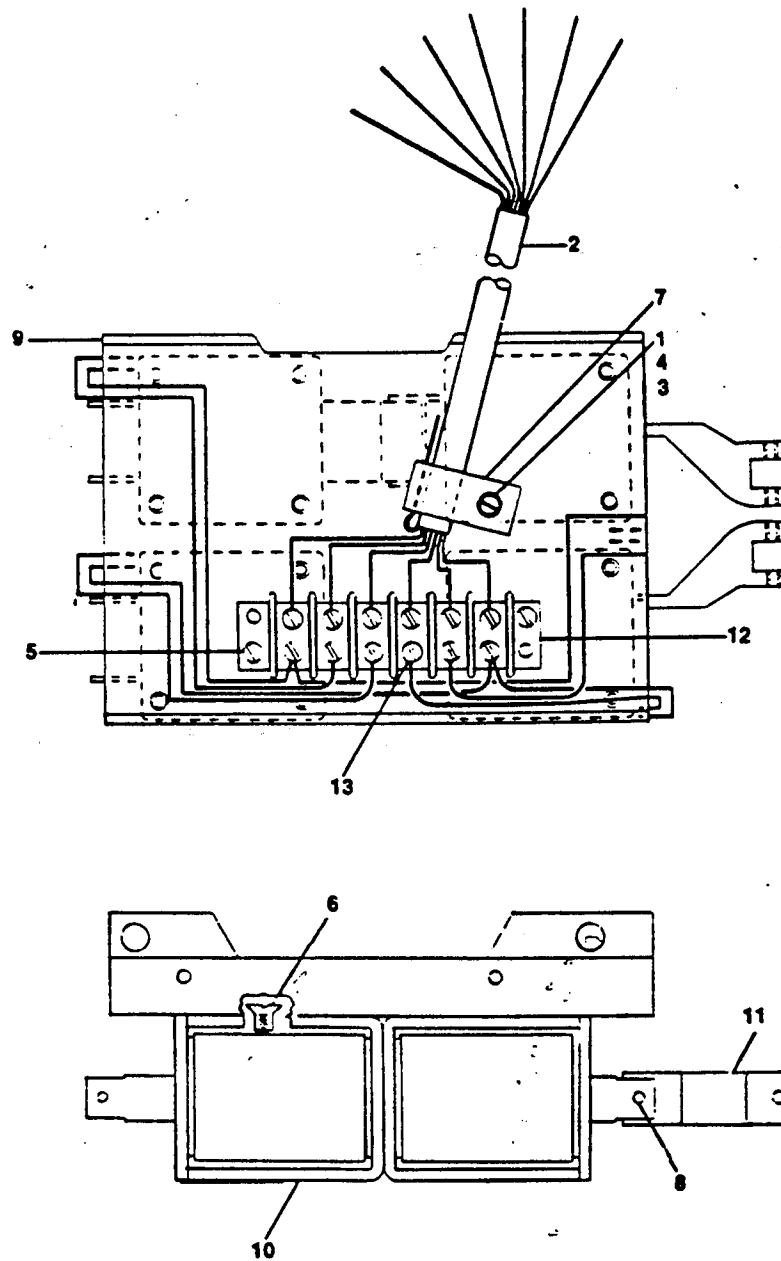
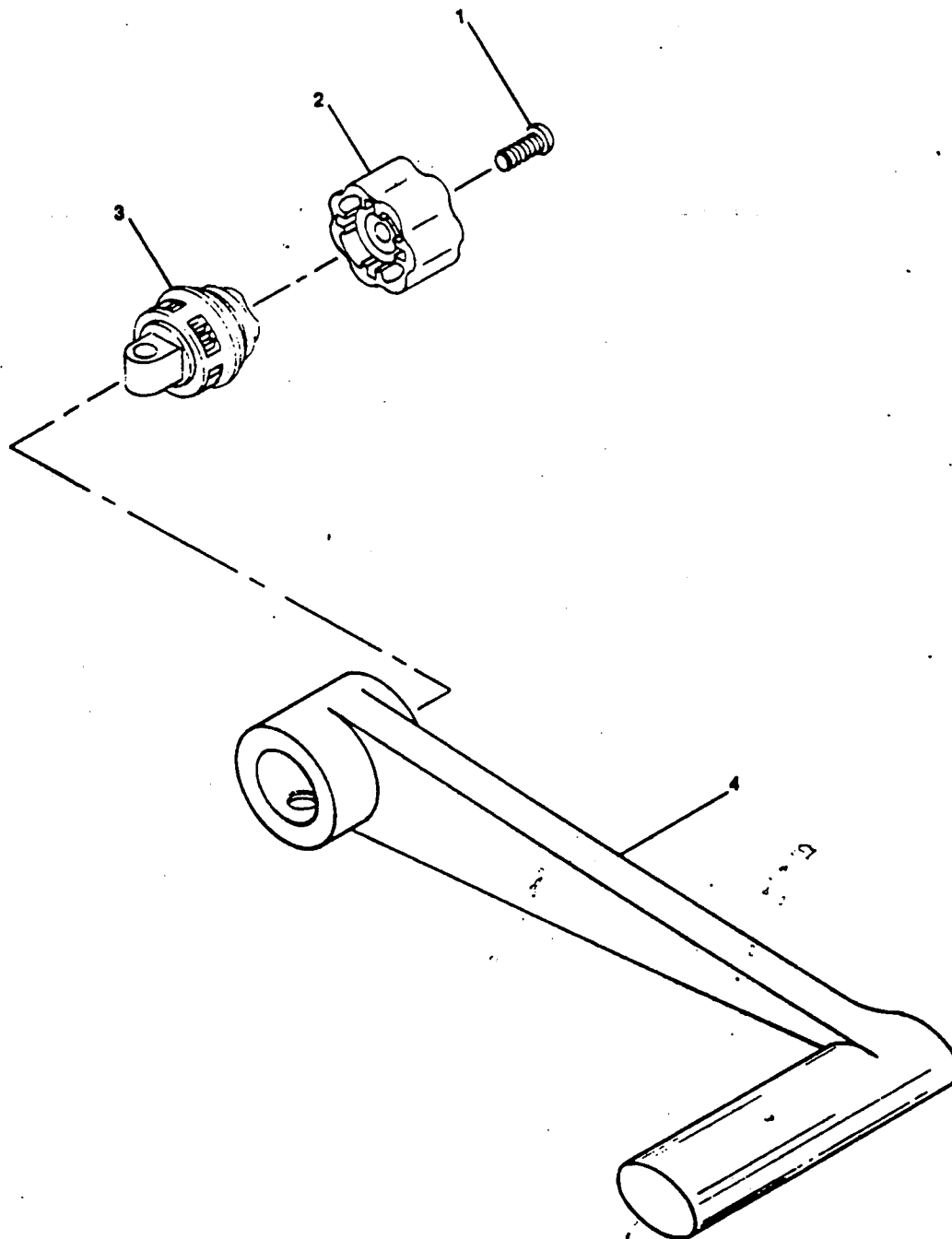


Figure 8-17. 2080RC TRENDLENBURG SOLENOID ASSEMBLY

FIG & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
8-17-	55039-091	2080RC TRENDELENBURG SOLENOID ASSEMBLY				
1	3984-041	SCREW, Round Head .....	1	A/R		
2	R4018-713	CABLE, Belden, 18/7 Conductor, 4 ft. ....	1			
3	5469-041	WASHER .....	1			
4	19675-041	LOCKWASHER .....	1			
5	21711-042	SCREW, Round Head .....	2			
6	38698-041	SCREW, Flat Head, 8-32 x 1/4 .....	8			
7	41288-091	CLAMP, Cable .....	1			
8	45591-061	PIN, Roll .....	2			
9	55137-010	SUPPORT .....	1			
10	81009-091	SOLENOID .....	2			
11	81010-091	CONNECTOR .....	2			
12	89174-091	BOARD, Terminal .....	1			
13	90619-091	TERMINAL .....	14			



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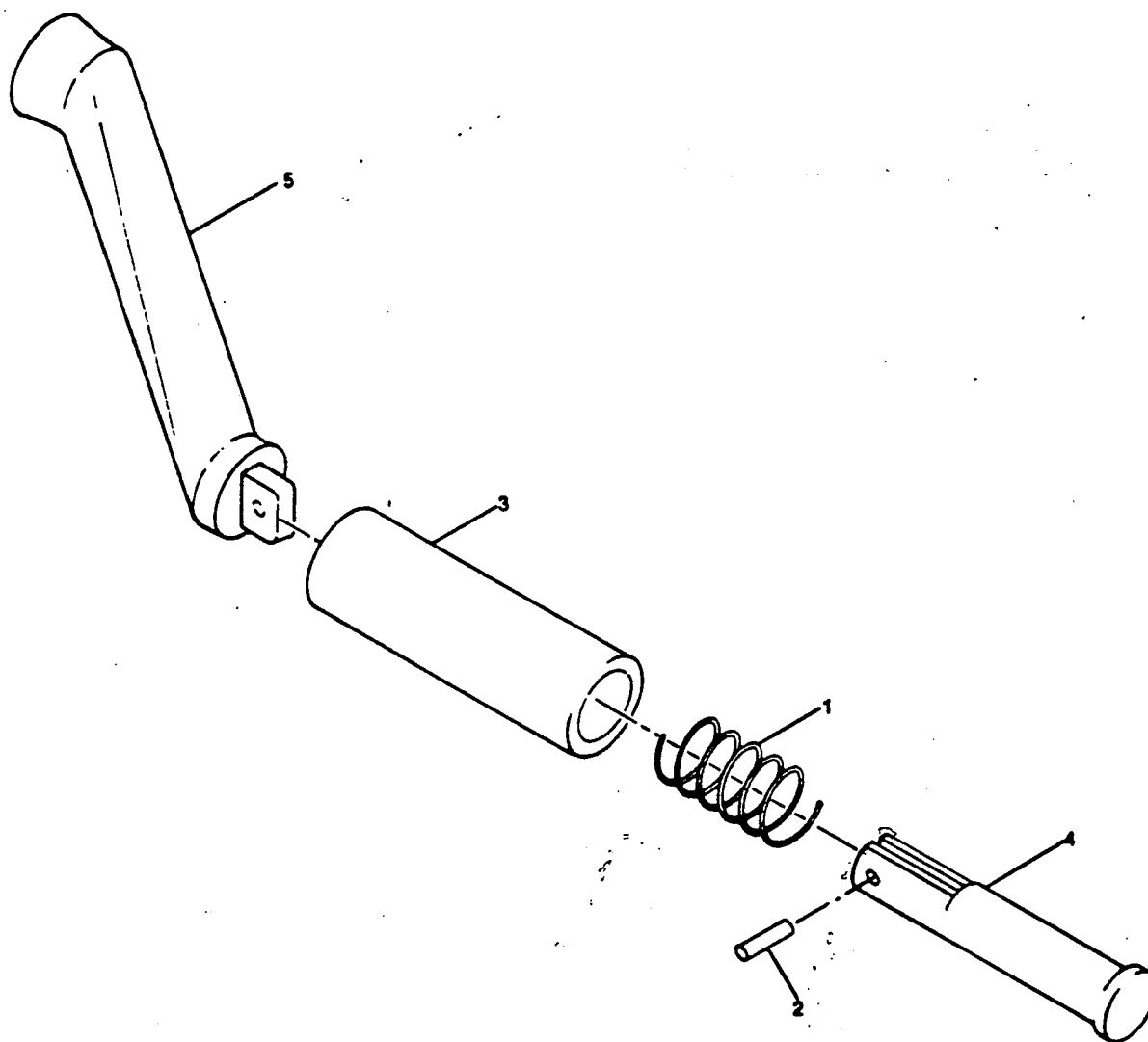


**Figure 8-18. KIDNEY ELEVATOR HANDLE RATCHET ASSEMBLY  
UNITS SHIPPED BEFORE 8/74.**



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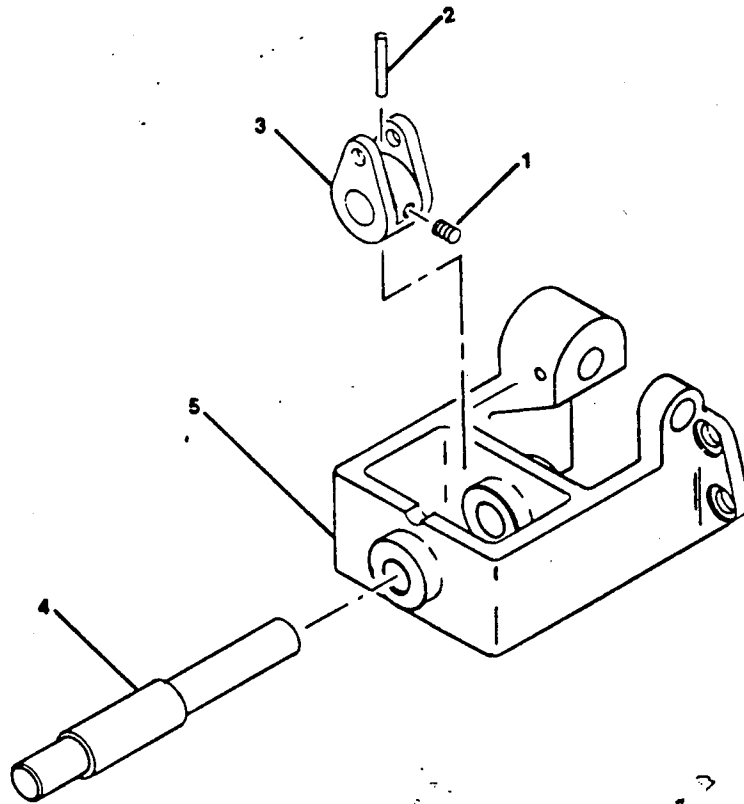
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**Figure 8-18A. KIDNEY ELEVATOR CRANK ASSEMBLY;  
UNITS SHIPPED AFTER 8/74.**

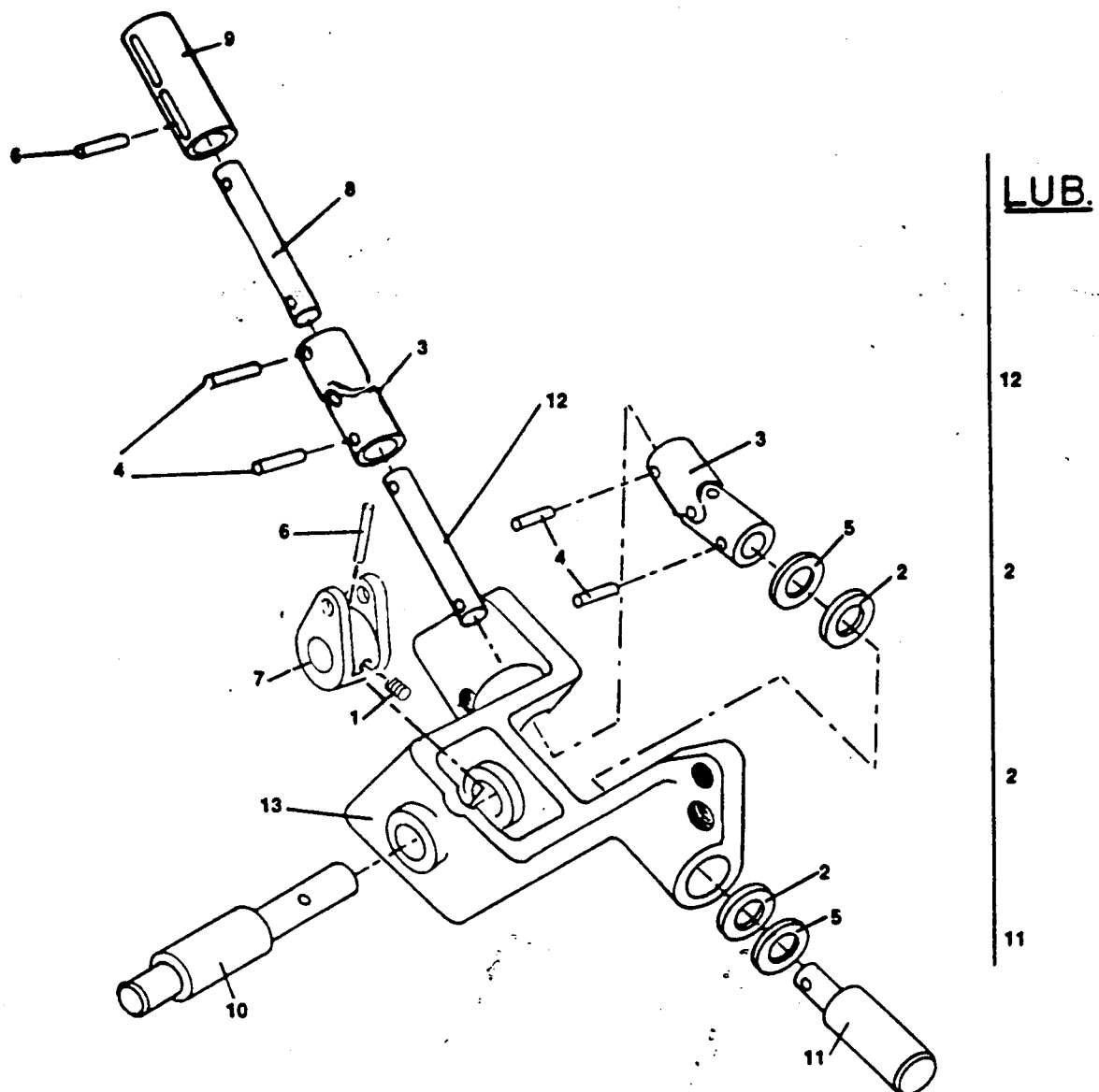
FIG & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
8-18A-	92588-001	KIDNEY ELEVATOR CRANK ASSEMBLY (Units Shipped After 8/74)				
	1 36747-091	SPRING, Compression .....	1			
	2 43227-061	PIN, Roll .....	1			
	3 55143-091	HANDLE, Crank .....	1			
	4 82604-001	PIN, Handle .....	1			
	5 92587-001	CRANK, Kidney Elevator .....	1			

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**Figure 8-19. SUPPORT ASSEMBLY; UNITS SHIPPED BEFORE 8/74**

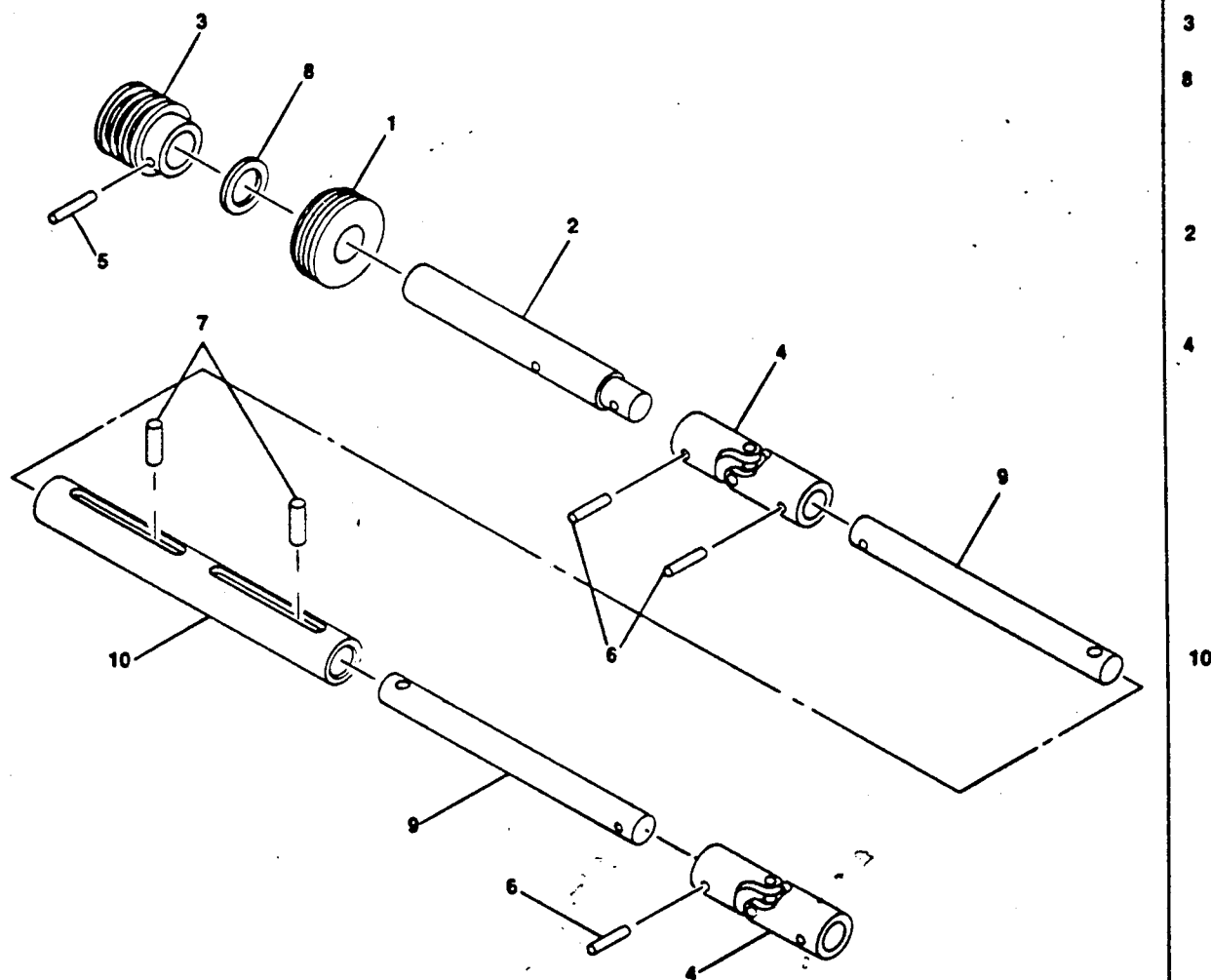
FIG & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
8-19-	†55138-091	SUPPORT ASSEMBLY (Units Shipped Before 8/74)				
1	10585-041	SETSCREW .....	1			
2	43227-061	PIN, Roll .....	1			
3	43306-091	CLEVIS .....	1			
4	77668-061	PIN, Trendelenburg Mounting .....	1			
5	135282-001	SUPPORT .....	1			
†Order conversion kit Q-760139-091 to replace ratchet-type kidney elevator drive with crank-type drive.						



**Figure 8-19A. KIDNEY ELEVATOR SUPPORT ASSEMBLY  
UNITS SHIPPED AFTER 8/74.**

FIG & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
8-19A-	135983-001	KIDNEY ELEVATOR SUPPORT ASSEMBLY (Units Shipped After 8/74)				
	1	10585-041 SETSCREW, 10-32 x 1/4 .....	1			
	2	16952-091 WASHER .....	2			
	3	20200-045 JOINT, Universal .....	2			
	4	41511-061 PIN, Groove, 5/32 x 5/8 .....	4			
	5	42639-091 RING, Retaining .....	2			
	6	43227-061 PIN, Roll .....	2			
	7	43306-091 CLEVIS .....	1			
	8	77551-061 SHAFT .....	1			
	9	77552-061 COUPLING .....	1			
	10	77668-061 PIN, Trendelenburg Mounting .....	1			
	11	82605-001 SHAFT, Crank .....	1			
	12	82606-001 SHAFT, Connecting .....	1			
	13	135942-001 SUPPORT .....	1			

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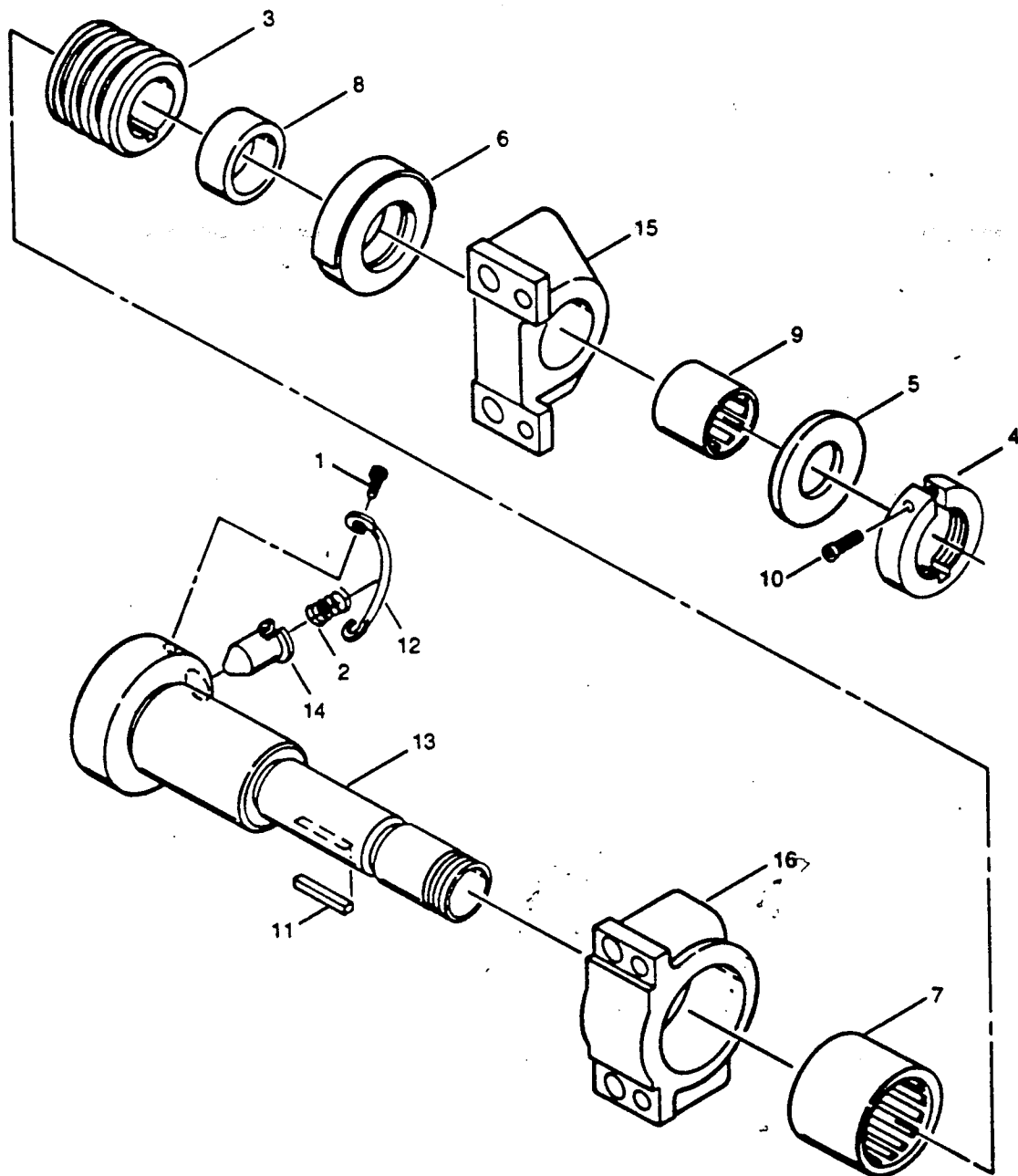


**Figure 8-20. KIDNEY ELEVATOR SHAFT ASSEMBLY  
UNITS SHIPPED BEFORE 8/74.**



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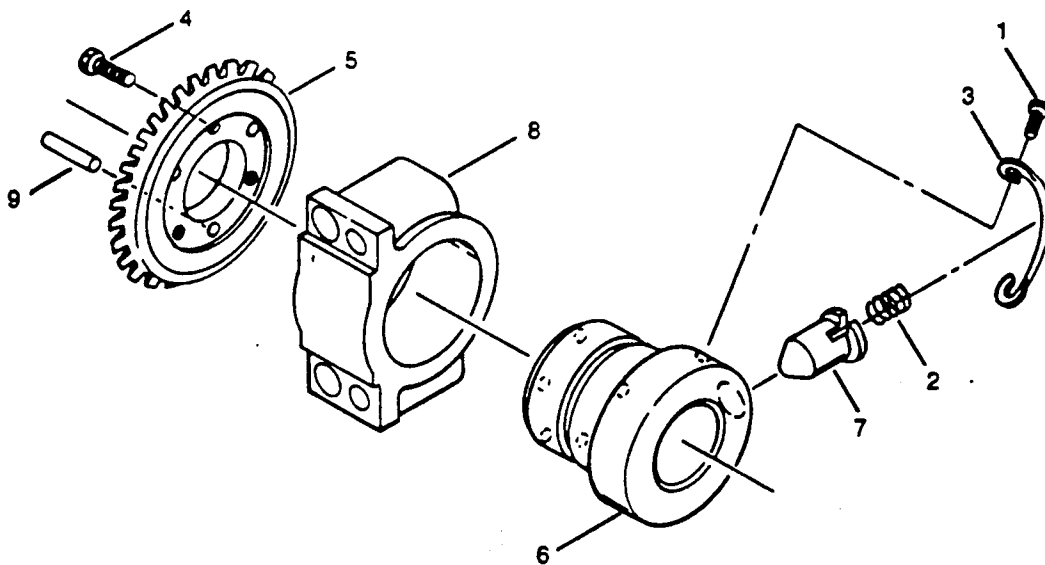
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Figure 8-21A. BACK SECTION DRIVE ASSEMBLY.

FIG. & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
8-21A	134189-001	BACK SECTION DRIVE ASSEMBLY				
1	9374-041	SCREW, 10-32 x 3/8 .....	2			
2	14397-091	SPRING .....	1			
3	16105-091	GEAR, Worm .....	1			
4	16115-091	NUT, Adjusting .....	1			
5	16201-091	WASHER, Thrust .....	1			
6	16204-091	BEARING, Thrust .....	1			
7	16233-091	BEARING, Needle .....	1			
8	16256-091	SPACER .....	1			
9	16271-091	BEARING, Needle .....	1			
10	16425-041	SCREW, Cap, 10-32 x 3/4 .....	1			
11	16428-091	KEY .....	1			
12	16439-091	RETAINER, Key .....	1			
13	28046-091	HEAD, Drive .....	1			
14	28050-091	KEY .....	1			
15	43323-091	BEARING .....	1			
16	52806-001	BEARING, Shaft .....	1			

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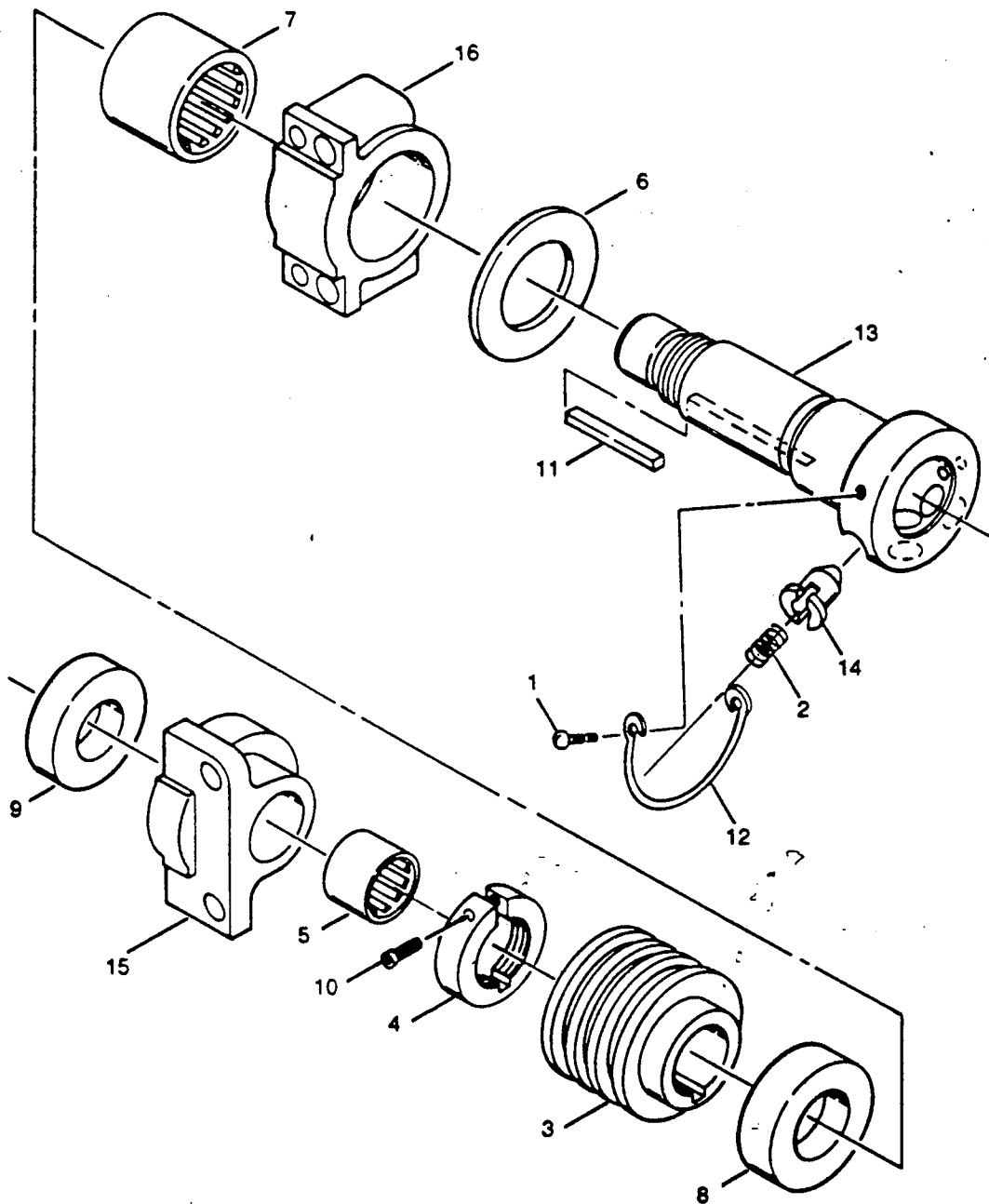
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Figure 8-21B. SIDE TILT DRIVE ASSEMBLY.

FIG. & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
8-21B	134186-001	SIDE TILT DRIVE ASSEMBLY				
1	9374-041	SCREW, 10-32 x 3/8 .....	2			
2	14397-091	SPRING .....	1			
3	16439-091	RETAINER, Key .....	1			
4	16451-042	SCREW, 10-32 x 5/8 .....	3			
5	22728-091	GEARS, Drive (Includes 16111 and 16110) .....	1			
6	28048-091	HEAD, Drive .....	1			
7	28050-091	KEY .....	1			
8	43213-091	BEARING, Shaft .....	1			
9	43300-061	PIN, Roll .....	3			

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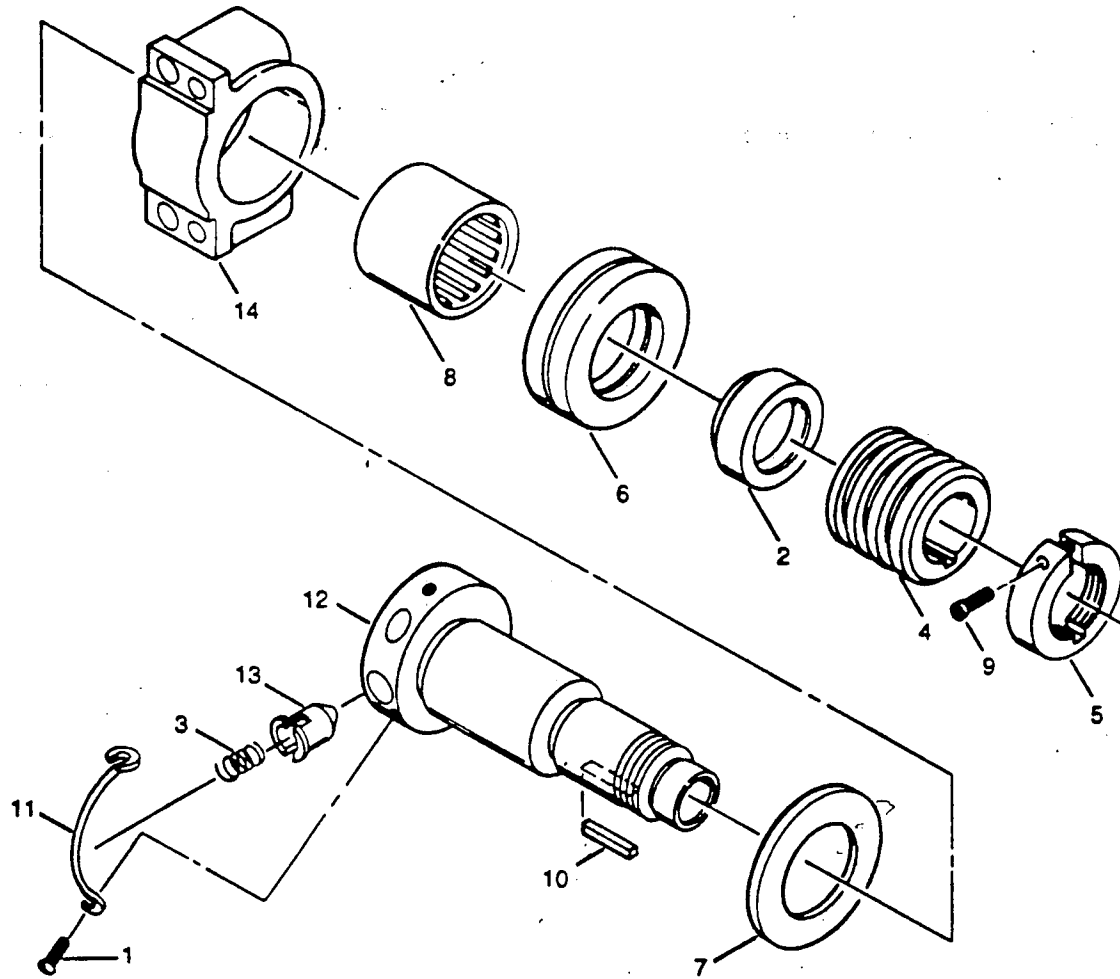
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Figure 8-21C. SEAT SECTION DRIVE ASSEMBLY.

FIG. & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
8-21C	134188-001	SEAT SECTION DRIVE ASSEMBLY				
1	9374-041	SCREW, 10-32 x 3/8 .....	2			
2	14397-091	SPRING .....	3			
3	16107-091	GEAR, Worm .....	1			
4	16184-091	NUT, Adjusting .....	1			
5	16213-091	BEARING, Needle .....	1			
6	16214-091	WASHER .....	2			
7	16233-091	BEARING, Needle .....	3			
8	16249-091	BEARING .....	1			
9	16281-091	BEARING, Ball .....	1			
10	16425-041	SCREW, Cap, 10-32 x 3/4 .....	1			
11	16426-091	KEY .....	1			
12	16485-091	RETAINER, Key .....	1			
13	28047-091	HEAD, Drive .....	1			
14	28050-091	KEY .....	3			
15	43217-091	BEARING .....	1			
16	52806-001	BEARING, Shaft .....	1			

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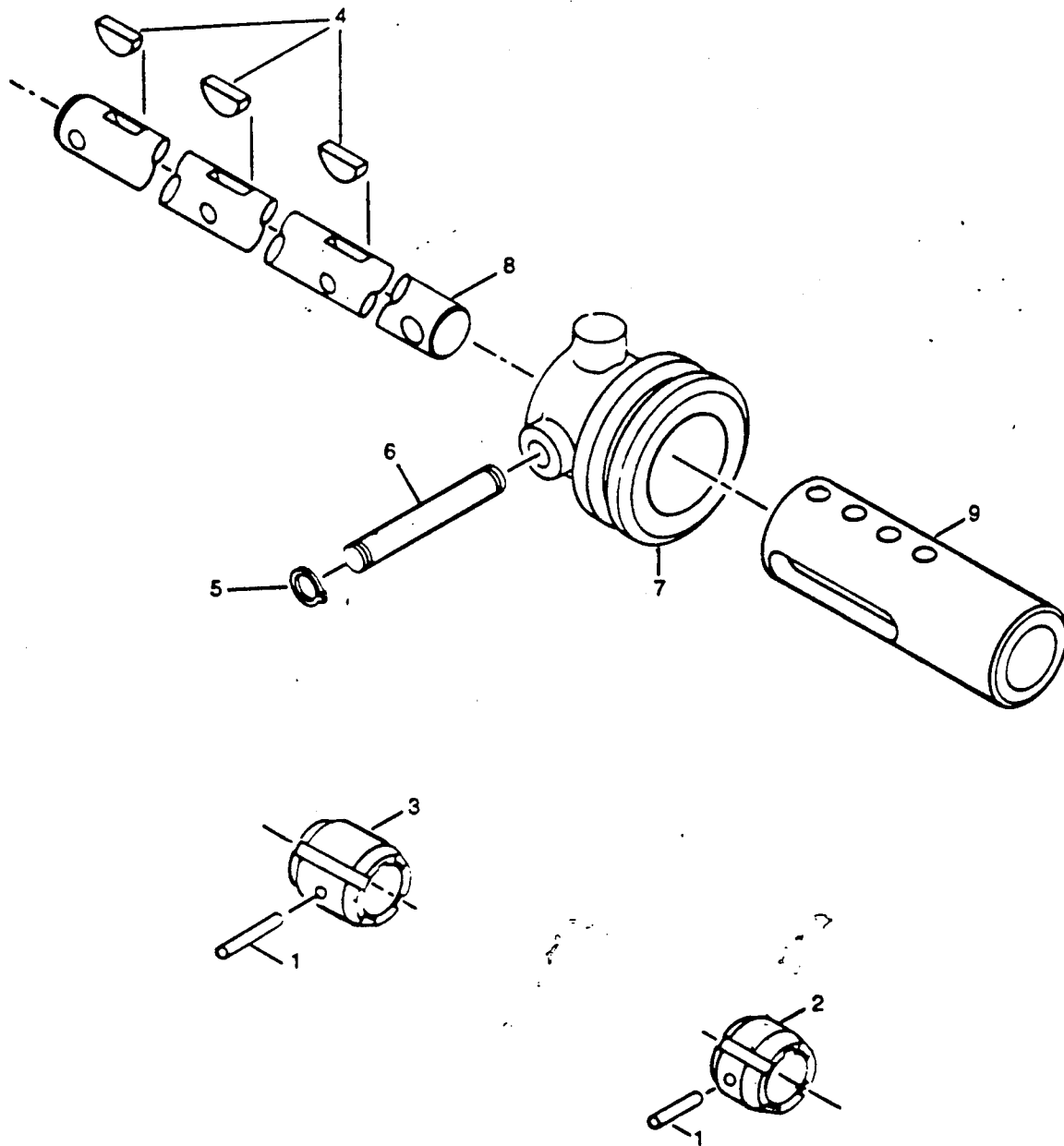
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Figure 8-21D. LEG SECTION DRIVE ASSEMBLY.



FIG. & INDEX NO.	PART NUMBER	DESCRIPTION	U N
8-21D	134187-001	LEG SECTION DRIVE ASSEMBLY	
1	9374-041	SCREW, 10-32 x 3/8 .....	2
2	13461-091	SPACER .....	1
3	14397-091	SPRING .....	2
4	16109-091	GEAR, Worm .....	1
5	16184-091	NUT, Adjusting .....	1
6	16209-091	BEARING, Ball .....	1
7	16214-091	WASHER .....	2
8	16233-091	BEARING, Needle .....	1
9	16425-041	SCREW, Cap, 10-32 x 3/4 .....	1
10	16427-091	KEY .....	1
11	16439-091	RETAINER, Key .....	1
12	28049-091	HEAD, Drive .....	1
13	28050-091	KEY .....	2
14	52806-001	BEARING, Shaft .....	1

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Figure 8-21E. 2080RC SPECIAL PARTS.

FIG. & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
8-21E	150125-001	2080 RC SPECIAL PARTS				
1	14394-045	PIN, Taper .....	3			
2	16185-091	CLUTCH .....	2			
3	16198-091	CLUTCH .....	1			
4	16261-091	KEY .....	3			
5	31952-091	RING, Retaining .....	2			
6	43230-091	PIN .....	1			
7	43235-091	SPOOL, Shifter .....	1			
8	43267-091	SHAFT, Main .....	1			
9	49035-091	SLEEVE, Shifter .....	1			

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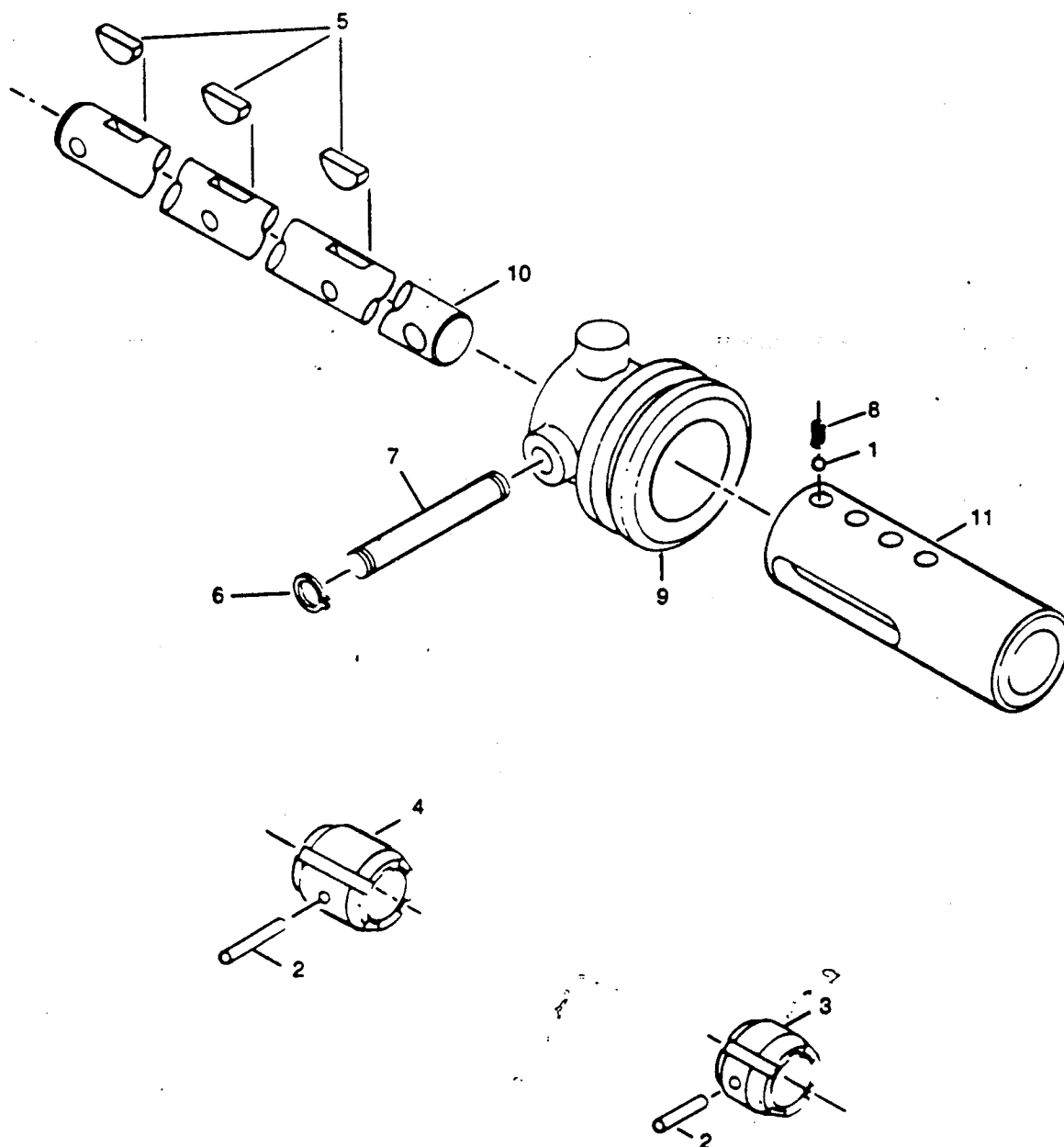
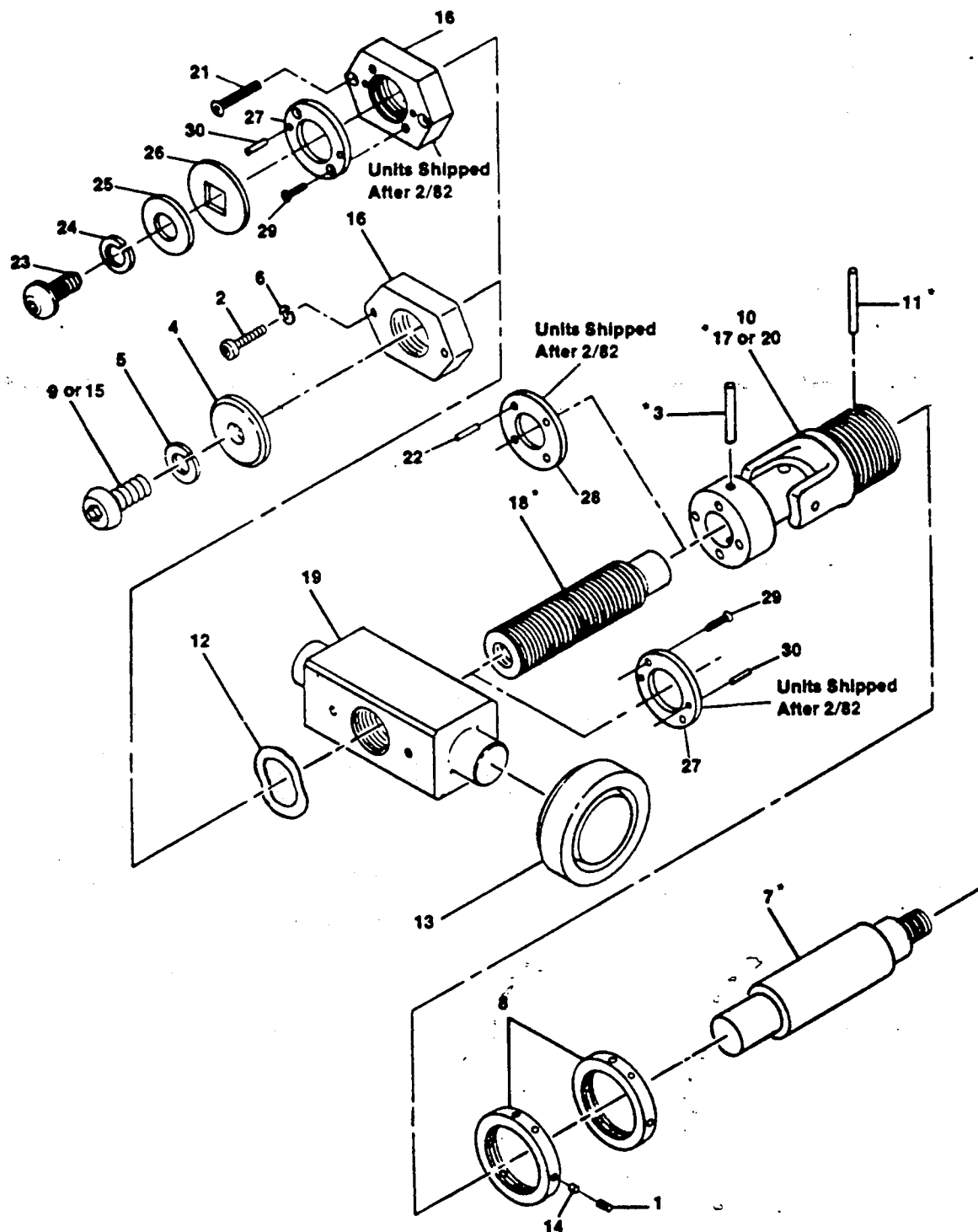
**Figure 8-22. 2080L AND 2080 SPECIAL PARTS.**

FIG. & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
8-22	150126-001	2080L AND 2080 SPECIAL PARTS				
1	12608-061	BALL .....	1			
2	14394-045	PIN, Taper .....	3			
3	16185-091	CLUTCH .....	2			
4	16198-091	CLUTCH .....	1			
5	16261-091	KEY .....	3			
6	31952-091	RING, Retaining .....	2			
7	43230-091	PIN .....	1			
8	43232-091	SPRING .....	1			
9	43235-091	SPOOL, Shifter .....	1			
10	43267-091	SHAFT, Main .....	1			
11	49035-091	SLEEVE, Shifter .....	1			



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Figure 8-23. SIDE TILT SCREW ASSEMBLY

\*See Note on Page 8-76.

FIG & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
8-23-	55122-001	SIDE TILT SCREW ASSEMBLY (Units Shipped Before 6/72)	X			
	56049-001	SIDE TILT SCREW ASSEMBLY (Units Shipped Between 6/72 and 7/75)		X		
	136210-001	SIDE TILT SCREW ASSEMBLY (Units Shipped Between 7/75 and 7/79) .....			X	
		SIDE TILT SCREW ASSEMBLY (Units Shipped After 7/79) .....				X
1	10583-091	SETSCREW .....	2	2	2	2
2	13102-045	SCREW, Socket Head, 10-32 x 1 .....	2	2	2	—
3	14394-045	PIN, Taper .....	2	2	2	2
4	16299-051	WASHER, Bevel .....	1	1	1	—
5	19687-061	LOCKWASHER .....	1	1	1	—
6	46115-091	LOCKWASHER .....	2	2	2	—
7	75818-091	SHAFT, Drive .....	1	1	1	1
8	75819-045	NUT .....	2	2	2	2
9	76779	SCREW, Button Head, 3/8-15 x 3/4 (Units Shipped Before 6/72) (Sub: 81591-001) .....	1	—	—	—
10	78246-091	JOINT, Universal (Units Shipped Before 6/72) .....	1	—	—	—
11	79592-045	PIN, Taper .....	2	2	2	2
12	80107-091	WASHER, Spring .....	1	1	1	1
13	80112-091	BEARING .....	2	2	2	2
14	80203-091	PLUG, Nylon .....	2	2	2	2
15	81591-001	SCREW, Button Head, 3/8-16 x 3/4 (Units Shipped After 6/72) .....	—	1	1	—
16	83250-002	NUT, Adjusting .....	1	1	1	1
17	92128-001	JOINT, Universal (Units Shipped Between 6/72 and 7/75) .....	—	1	—	—
18	92945-001	SCREW, Power .....	1	1	1	1
19	92946-001	NUT, Side Tilt .....	1	1	1	1
20	92947-001	JOINT, Universal (Units Shipped After 7/75) .....	—	—	1	1
21	150675-001	SCREW, Nylock, Fl. Hd., 10-32 x 1 .....				2
22	36683-061	PIN, Roll, 1/8 x 1/2 .....				8
23	42631-045	SCREW, Button Hd., 1/4-20 x 1/2 .....				1
24	19686-061	LOCKWASHER, 1/4 .....				1
25	5575-091	WASHER, Flat, 1/4 .....				1
26	83253-001	WASHER, Stop, Square Hole .....				1
27	83251-001	WASHER, Stop, 7/8 I.D. ....				2
28	83252-001	WASHER, Stop, 5/8 I.D. ....				1
29	50347	SCREW, Fl. Hd., 6-32 x 3/8 (Sub: 150824-132) .....				4
30	36683-061	PIN, Roll, 1/8 x 1/2 .....				8
*NOTE: Items 3, 7, 11, 17 and 18 should not be disassembled; they are shown disassembled for clarity.						

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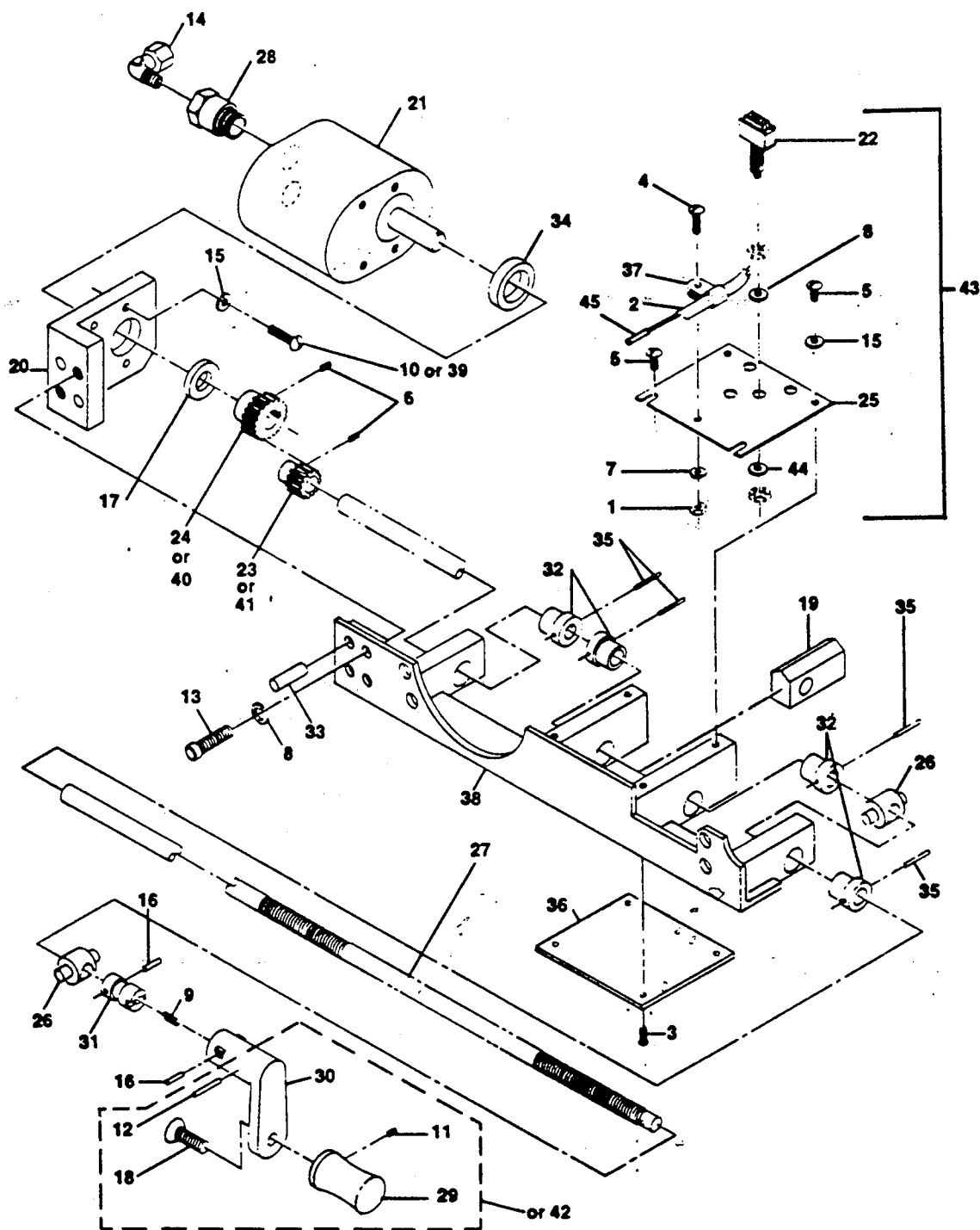


Figure 8-24. 2080RC SELECTOR ASSEMBLY



FIG & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
8-24-	99428-091	2080RC SELECTOR ASSEMBLY				
1	3153-041	NUT .....	1			
2	R-4018-012	CABLE, 18/12 wire, 27' .....	A/R			
3	4617-041	SCREW, Flat Head, 8-32 x 3/8 .....	4			
4	9288-041	SCREW, 8-32 x 1/2 .....	1			
5	9374-041	SCREW, Round Head, 10-32 x 3/8 .....	4			
6	10583-091	SETSCREW .....	2			
7	19676-041	LOCKWASHER .....	1			
8	19678-045	LOCKWASHER .....	6			
9	39462-091	SPRING .....	1			
10	39644-048	SCREW, Round Head, 10-24 x 3/4 .....	4			
11	42617-045	SETSCREW .....	1			
12	43308-061	PIN, Roll .....	1			
13	44551-041	SCREW, Socket Head, 1/4-20 x 1, Nylock .....	2			
14	45407-042	ELL, Compression .....	2			
15	46115-091	LOCKWASHER .....	6			
16	47383-091	PIN, Roll .....	2			
17	52727-091	BEARING .....	1			
18	75331-061	SCREW, Flat Head 1/4-20 x 3/4 .....	1			
19	77649-091	CAM .....	1			
20	77689-091	BRACKET, Motor .....	1			
21	78206-091	MOTOR, Fluid .....	1			
22	78211-091	SWITCH .....	4			
23	N.L.A. (78218)	GEAR, Spur .....	1			
24	N.L.A. (78219)	GEAR, Spur .....	1			
25	78276-061	PLATE, Switch Mounting .....	1			
26	78278-091	NUT .....	2			
27	78280-061	SHAFT .....	1			
28	78282-091	ADAPTER, Fitting .....	2			
29	78288-056	KNOB .....	1			
30	78290-001	HANDLE .....	1			
31	78301-001	GUIDE, Power Screw .....	1			
32	80113-091	BEARING, Guide .....	4			
33	80118-091	PIN, Dowel .....	2			
34	80120-091	RING, Pilot .....	1			
35	80211-061	PIN, Dowel .....	4			
36	80212-061	GUIDE, Cam .....	1			
37	118154-091	CLAMP .....	1			
38	133680-001	PLATE, Mounting .....	1			
39	36944-041	SCREW, Rd. Hd., 10-24 x 3/4 .....	4			
40	150744-001	GEAR, Spur .....	1			
41	150743-001	GEAR, Spur .....	1			
42	78296-001	HANDLE ASS'Y. (Includes Items 11, 12, 18, 29 & 30) .....	1			
43	55038-091	LIMIT SWITCH ASS'Y. (Includes 1, 2, 4, 7, 22, 25, 37, 43, 44) .....	1			
44	49134-061	WASHER, Flat, 7/64 I.D. ....	8			
45	80981-091	CONNECTOR, Butt .....	4			

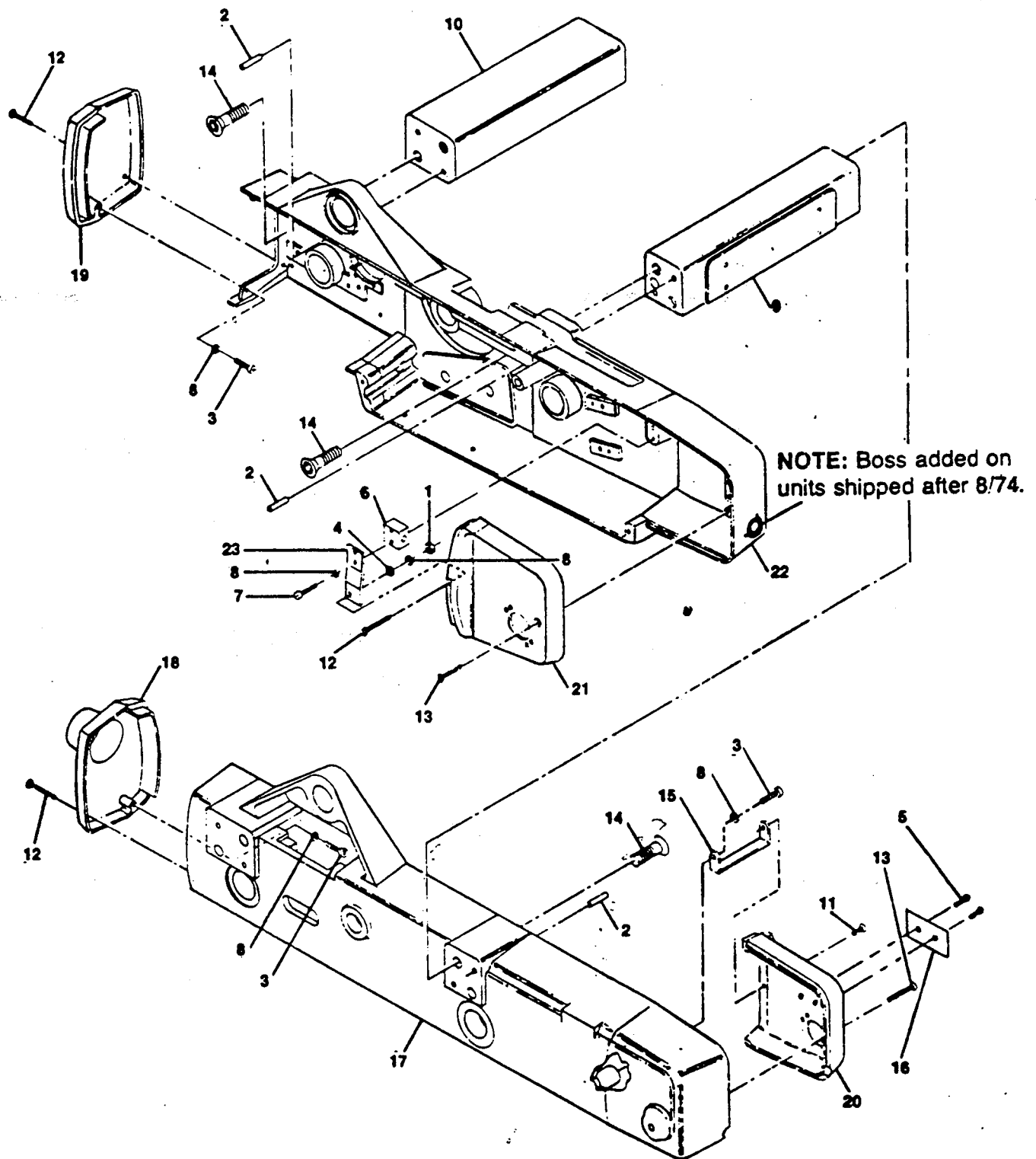


Figure 8-25. 2080RC SIDE FRAME ASSEMBLY

FIG & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
8-25-	133670-001	2080RC SIDE FRAME ASSEMBLY (Units Shipped Before 8/74)	X			
	134067-006	2080RC SIDE FRAME ASSEMBLY (Units Shipped After 8/74)		X		
1	2960-042	NUT, Hex, 10-32 .....	1	1		
2	16424-091	PIN, Dowel .....	8	8		
3	16425-041	SCREW, Socket Head, 10-32 x 3/4 .....	3	3		
4	17589-045	WASHER .....	1	1		
5	34567-045	SCREW .....	2	2		
6	43309-091	GUIDE .....	1	1		
7	44876-041	SCREW, Cap, 10-24 x 1-1/4 .....	2	2		
8	46115-091	LOCKWASHER .....	6	6		
9	54661-002	CROSSPIECE .....	1	1		
10	55092-091	CROSSPIECE .....	1	1		
11	55281-002	SCREW, Flat Head Socket, 10-32 x 3/4 .....	1	1		
12	55281-003	SCREW, Flat Head Socket, 10-32 x 1-1/4 .....	5	5		
13	55281-004	SCREW, Flat Head Socket, 10-32 x 1-1/2 .....	2	2		
14	75881-042	SCREW, Flat Head Socket, 5/8-11 x 1-3/4 .....	8	8		
15	78221-010	SUPPORT, Cover .....	1	1		
16	81403-001	PLATE, Warning .....	1	1		
17	141175-001	FRAME, Drive Side .....	1	1		
18	133655-091	CAP, End, Drive Side .....	1	1		
19	133660-091	CAP, End, Trendelenburg Side .....	1	1		
20	133667-091	COVER, Drive .....	1	1		
21	133668-091	COVER, Trendelenburg .....	1	1		
22	133689-002	FRAME, Trendelenburg Side .....	1	1		
23	150173-001	BRACKET, Support .....	1	1		

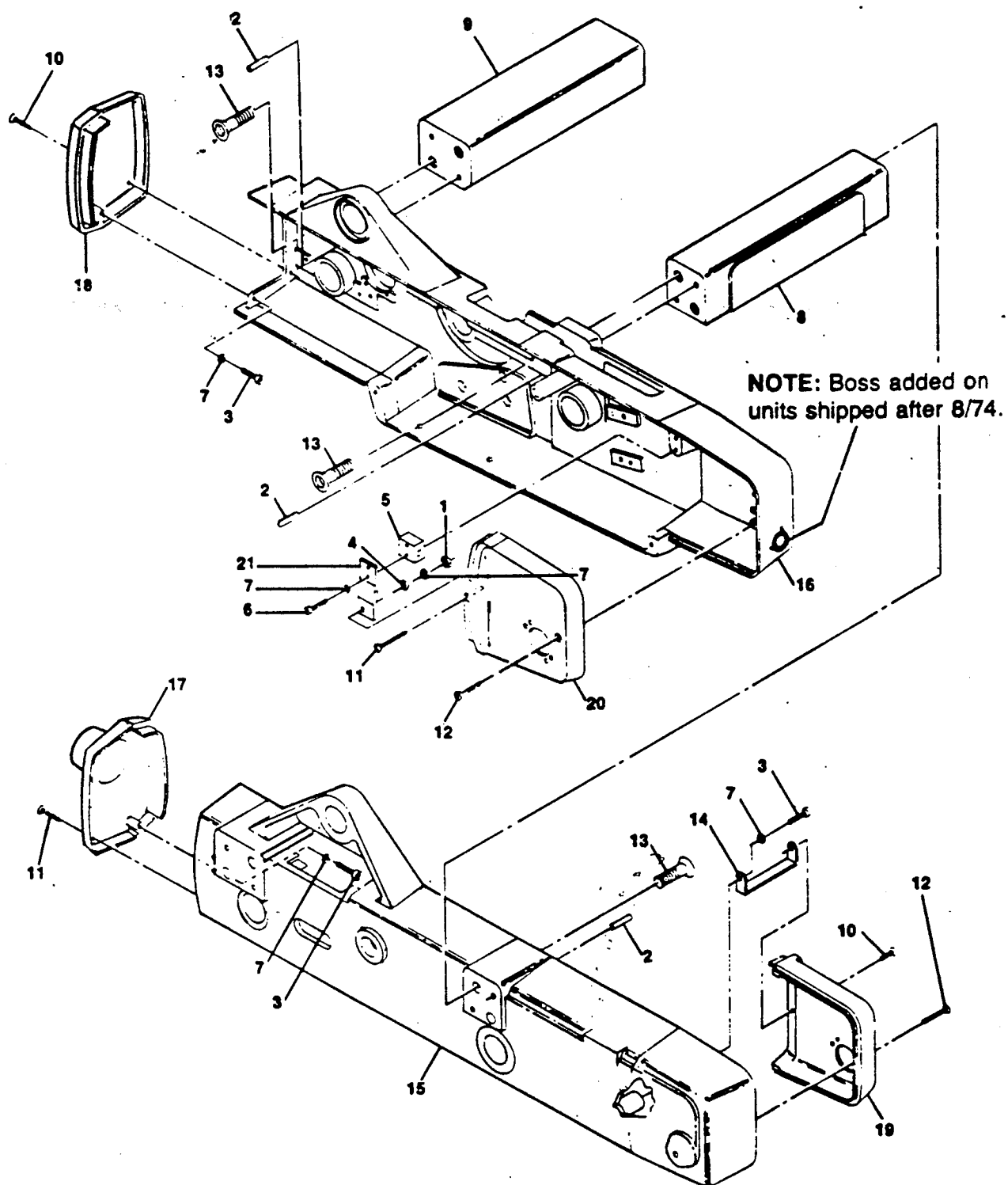


Figure 8-26. 2080L AND 2080 COMPAT SIDE FRAME ASSEMBLY

FIG & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
8-26-	133670-002	2080L SIDE FRAME ASSEMBLY (Units Shipped Before 8/74)	X			
	134067-005	2080L AND 2080 COMPAT SIDE FRAME ASSEMBLY (Units Shipped After 8/74)		X		
1	2960-042	NUT, Hex. 10-32 .....	1	1		
2	16424-091	PIN, Dowel .....	8	8		
3	16425-041	SCREW, Socket Head, 10-32 x 3/4 .....	3	3		
4	17589-045	WASHER .....	1	1		
5	43309-091	GUIDE .....	1	1		
6	44876-041	SCREW, Cap. 10-24 x 1-1/4 .....	2	2		
7	46115-091	LOCKWASHER .....	6	6		
8	54661-001	CROSSPIECE .....	1	1		
9	55092-091	CROSSPIECE .....	1	1		
10	55281-002	SCREW, Flat Head Socket, 10-32 x 3/4 .....	1	1		
11	55281-003	SCREW, Flat Head Socket, 10-32 x 1-1/4 .....	5	5		
12	55281-004	SCREW, Flat Head Socket, 10-32 x 1-1/2 .....	2	2		
13	75881-042	SCREW, Flat Head Socket, 5/8-11 x 1-3/4 .....	8	8		
14	78221-010	SUPPORT, Cover .....	1	1		
15	141175-001	FRAME, Drive Side .....	1	1		
16	99319-002	FRAME, Trendelenburg Side .....	1	1		
17	133655-091	CAP. End. Drive Side .....	1	1		
18	133660-091	CAP. End. Trendelenburg Side .....	1	1		
19	133667-091	COVER, Drive .....	1	1		
20	133668-091	COVER, Trendelenburg .....	1	1		
21	150173-001	BRACKET, Support .....	1	1		

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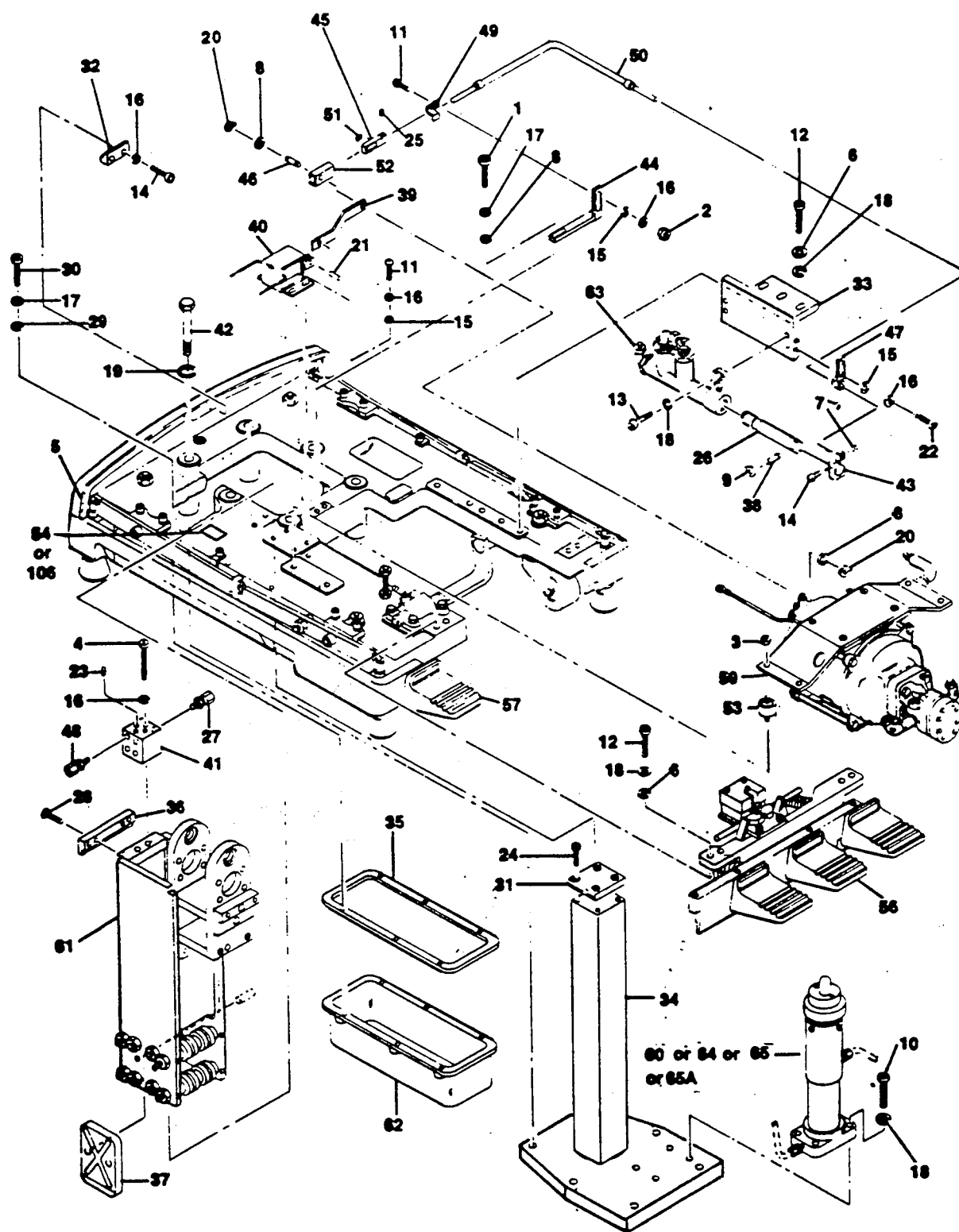


Figure 8-27. 2080RC BASE ASSEMBLY (Sheet 1 of 2)

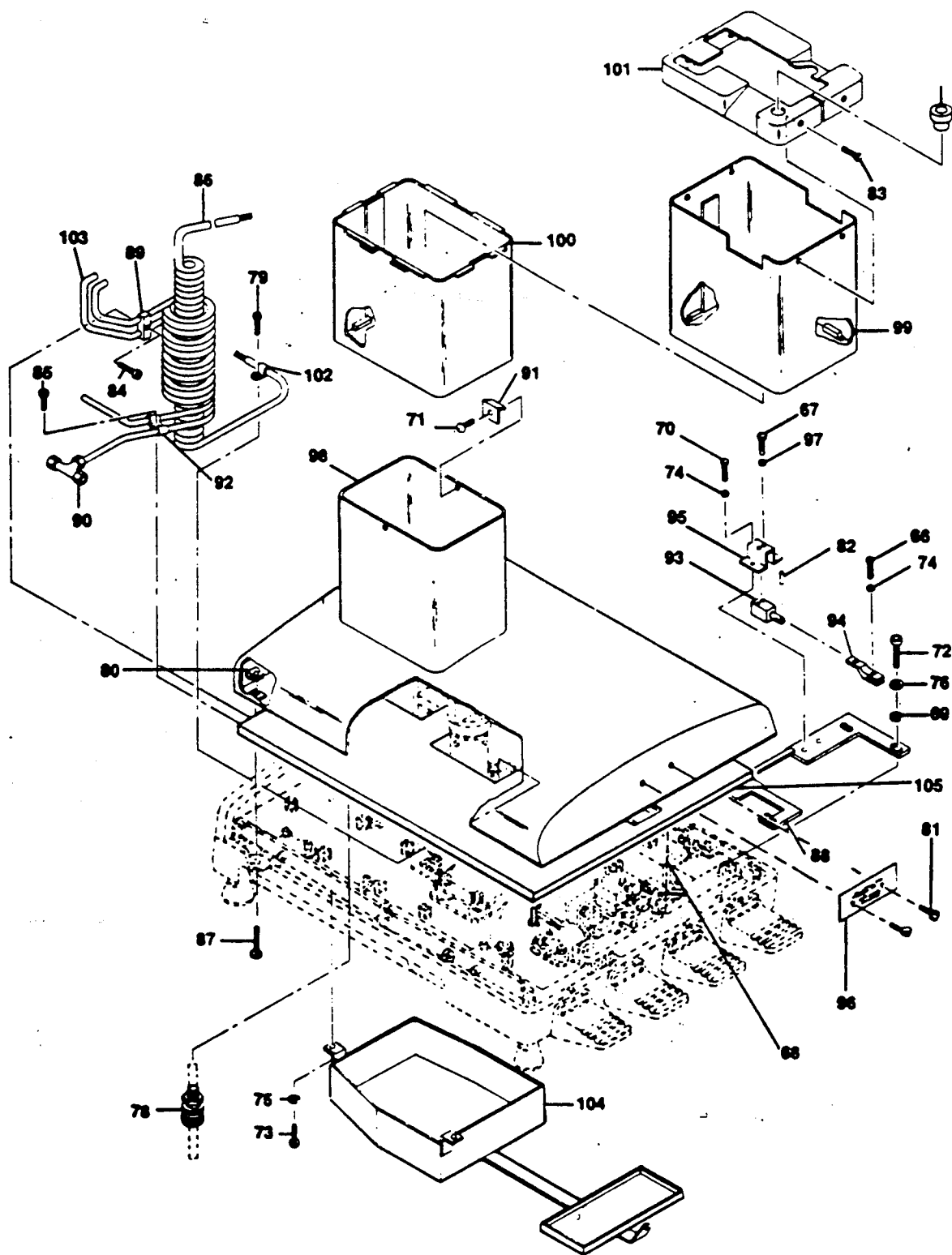


Figure 8-27. 2080RC BASE ASSEMBLY (Sheet 2 of 2)

FIG & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
8-27-	+99382-001	2080RC BASE ASSEMBLY				
		Sheet 1 of 2				
1	2792-045	SCREW, Socket Cap, 1/4-20 x 1/2 .....	2			
2	2959-041	NUT, Hex .....	2			
3	3097-041	NUT, Hex .....	6			
4	3876-061	SCREW, Phillips Head .....	2			
5	R-7200-426	GASKET, Scotch Foam Single Coated Black Vinyl Tape, 1/8" x 3/8" x 3 ft. ....	A/R			
6	10412-042	WASHER, Flat .....	7			
7	10585-041	SETSCREW, 10-32 x 1/4 .....	2			
8	11149-091	WASHER .....	3			
9	13320-091	RING, Retaining .....	2			
10	13796-045	SCREW, Cap Socket, 3/8-16 x 1-1/2 .....	4			
11	15287-041	SCREW, Round Head, 10-32 x 1/2 .....	6			
12	15339-045	SCREW, Socket Head, 3/8-16 x 1-1/4 .....	7			
13	16383-045	SCREW, Socket Head, 3/8-16 x 1 .....	12			
14	16425-041	SCREW, Socket Head, 10-32 x 3/4 .....	3			
15	17589-045	WASHER .....	10			
16	19677-041	LOCKWASHER .....	17			
17	19678-045	LOCKWASHER .....	8			
18	19680-041	LOCKWASHER .....	29			
19	19688-045	LOCKWASHER .....	6			
20	31689-045	RING, Retaining .....	2			
21	32528-091	SCREW, Round Head .....	1			
22	41012-061	SCREW, Socket Head, 10-32 x 1/2 .....	6			
23	42566-091	PLUG, Pipe .....	2			
24	43237-091	SCREW, Socket Head, 3/8-16 x 3/4 .....	4			
25	43259-091	SETSCREW, 6-32 x 3/16 .....	1			
26	43474-061	PISTON .....	1			
27	45565-091	COUPLING, Compression .....	2			
28	46124-056	SCREW, Flat Head, 1/4-20 x 3/4 .....	2			
29	49134-061	WASHER, Flat .....	6			
30	52718-091	SCREW, Socket Head, 1/4-20 x 2 .....	10			
31	52682-045	STOP, Elevator .....	1			
32	52728-091	SUPPORT, Cover .....	1			
33	55130-010	BRACKET, Pump Mounting .....	1			
34	55131-010	ELEVATOR ASSEMBLY .....	1			
35	55282-091	GASKET, Sump .....	1			
36	77525-045	SPACER .....	2			
37	77528-091	BEARING, Slide .....	2			
38	77590-061	PIN, Link .....	1			
39	77716-045	LEVER, Motor Actuating .....	1			
*NOTE 1: 99382-001 used on units shipped before 2/71. 99382-001 deleted and parts transferred to 99932-001 on units shipped after 2/71. On units shipped after 1/75, some parts transferred from 99932-001 to 99388-001 and from 99929-002 to 99932-001.						



FIG & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
Sheet 1 of 2						
8-27- 40	77717	SOLENOID ASSEMBLY (Sub. 56397-009).....	1			
41	78196-091	MANIFOLD .....	1			
42	78216-045	SCREW, Cap Hex Head, 7/16-20 x 5 .....	6			
43	78238-045	LEVER, Actuator .....	1			
44	78239-045	SUPPORT, Cable .....	1			
45	78240-091	SLIDE .....	1			
46	78241-061	PIN .....	1			
47	78242-042	BRACKET .....	1			
48	78292-091	COUPLING, Compression .....	4			
49	78302-091	CLIP .....	1			
50	78307-091	CABLE, Motor Start .....	1			
51	78309-091	SPRING .....	1			
52	78310-061	SLEEVE .....	1			
53	78319-091	MOUNT, Motor .....	4			
54	81141-001	LABEL, Oil Specification .....	1			
55	99047-091	BASE ELECTRIC COMPONENTS ASSEMBLY (Not Shown — See Fig. 8-29) .....	1			
56	99309-091	PEDAL ASSEMBLY (See Fig. 8-37) .....	1			
57	††99323-002	FLOOR LOCK ASSEMBLY (See Fig. 8-40) .....	1			
58	99388-002	PIPING ASSEMBLY (Not Shown — See Fig. 8-30) .....	1			
59	99426-002	MOTOR AND PUMP ASSEMBLY (See Fig. 8-38) .....	1			
60	NLA	LIFT CYLINDER ASSEMBLY (Units Shipped Before 10/72) (See Fig. 8-34) .....	1			
61	133636-001	TABLE SUPPORT ASSEMBLY (See Fig. 8-33) .....	1			
62	133661-010	SUMP .....	1			
63	133685-091	PUMP ASSEMBLY (See Fig. 8-31) .....	1			
64	NLA	LIFT CYLINDER ASSEMBLY (Units Shipped After 10/72) (See Fig. 8-36)	1			
65	NLA	LIFT CYLINDER ASSEMBLY (Units Shipped After 1/75) (See Fig. 8-37)	1			
65A	136375-001	LIFT CYLINDER ASSEMBLY (Units Shipped After 11/77) .....	1			
Sheet 2 of 2						
66	3964-041	SCREW, Round Head, 6-32 x 5/8 .....	2			
67	3967-041	SCREW, Round Head, 8-32 x 1/4 .....	4			
68	R-7200	GASKET, Scotch Foam Single Coated Black Vinyl Tape, 1/4" x 1/4" x 7 ft. (Sub: 764317-529) .....	A/R			
69	10412-042	WASHER, Flat .....	2			
70	12451-041	SCREW, Round Head, 6-32 x 1/4 .....	4			
71	13084-045	SCREW, Self Tapping, 6 x 3/16 .....	2			
72	15339-045	SCREW, Socket Head, 3/8-16 x 1-1/4 .....	2			
73	15361-042	SCREW, Round Head, 10-32 x 1/4 .....	3			
74	19675-041	LOCKWASHER .....	6			
75	19677-041	LOCKWASHER .....	3			
76	19680-041	LOCKWASHER .....	2			
77	30636-091	BUSHING, Strain Relief .....	1			
††NOTE 2: 99323-002 used on units shipped before 7/71. 99323-002 deleted and parts transferred to 99929-002, 134063-017, 134063-018, 134064-001 and 134064-002 on units shipped after 7/71. 99929-002 deleted and parts transferred to 99936-001 and 150128-001 on units shipped after 1/75.						

FIG & INDEX NO.		PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
Sheet 2 of 2							
8-27-	78	34111-091	CONNECTOR .....	1			
	79	41012-061	SCREW, Socket Head, 10-32 x 1/2 .....	1			
	80	44086-045	NUT, Speed .....	4			
	81	44438-061	SCREW, Self Tapping, 2 x 1/4 .....	2			
	82	45591-061	PIN, Roll .....	2			
	83	46123-010	SCREW, Phillips Head, 10-32 x 1/2 .....	4			
	84	46124-056	SCREW, Phillips Head, 1/4-20 x 3/4 .....	1			
	85	48060-091	SCREW, Socket Head, 1/4-20 x 3/4 .....	1			
	86	52690-091	CORD, Power .....	1			
	87	52718-091	SCREW, Socket Head, 1/4-20 x 2 .....	4			
	88	55274-010	PLATE, Mounting .....	1			
	89	78272-091	SPACER, Tube .....	1			
	90	78295-091	TEE, Union .....	1			
	91	80220-061	CLIP, Shroud .....	2			
	92	80925-061	CLAMP, Tube .....	1			
	93	81008	SOLENOID (Sub. 56397-010) .....	2			
	94	81010-091	CONNECTOR .....	2			
	95	81013-061	STRIP, Solenoid Mounting .....	2			
	96	81403-001	PLATE, Warning .....	1			
	97	90991-091	LOCKWASHER .....	4			
	98	99324-001	COVER ASSEMBLY .....	1			
	99	99326-001	SHROUD, Upper .....	1			
	100	99327-001	SHROUD, Intermediate .....	1			
	101	99425-002	COVER, Top .....	1			
	102	118155-091	CLIP, Plastic .....	2			
	103	133690-091	COIL, Tubing .....	1			
	104	133699-001	DRIP PAN ASSEMBLY .....	1			
	105	134125-001	BARRIER, Sound (Requires R-7200-428) .....	1			
	106	56397-013	LABEL, Oil Specification .....	1			

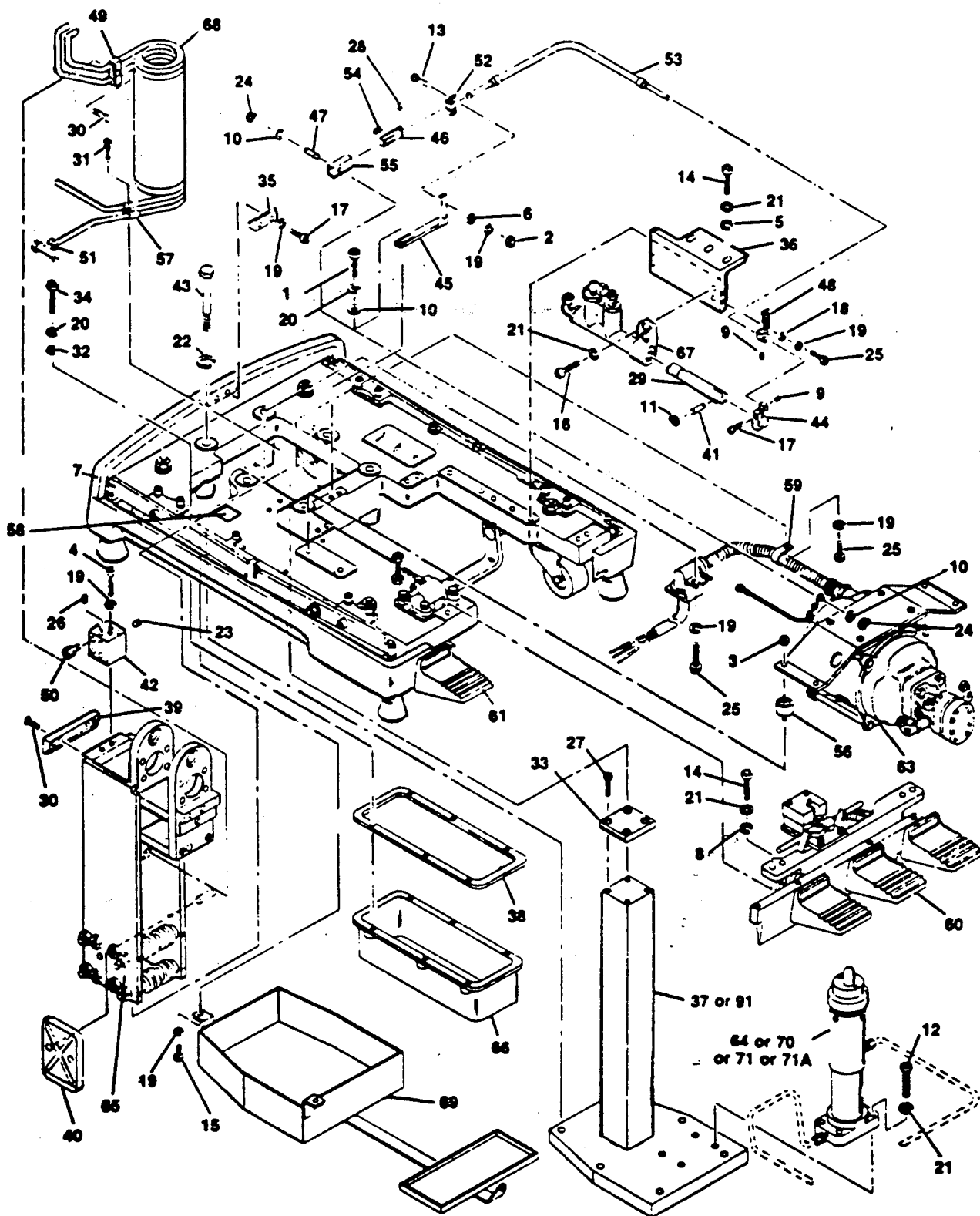


Figure 8-28. 2080L AND 2080 COMPAT BASE ASSEMBLY. Sheet 1 of 2

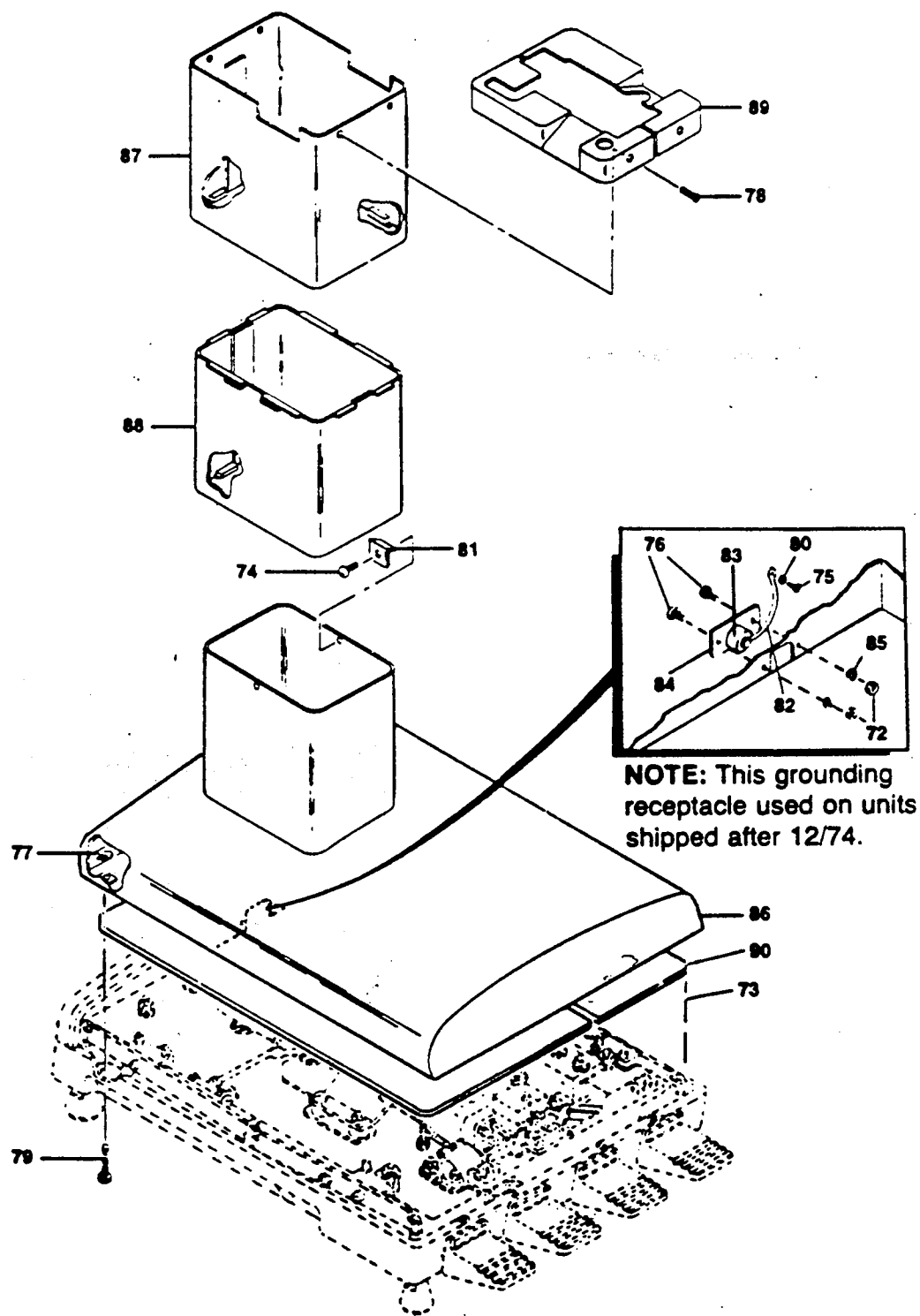


Figure 8-28. 2080L AND 2080 COMPAT BASE ASSEMBLY (Sheet 2 of 2)

FIG & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
8-28-	+99424-001	2080L BASE ASSEMBLY (Units Shipped Before 2/82)	X			
	146199-001	2080 COMPAT BASE ASSEMBLY		X		
	146199-001	2080L BASE ASSEMBLY (Units Shipped After 2/82)			X	
		Sheet 1 of 2				
1	2792-045	SCREW, Socket Head, 1/4-20 x 1/2 .....	2	2	2	
2	2959-041	NUT, Hex, 10-32 .....	2	2	2	
3	3097-041	NUT, Hex, 1/4-20 .....	4	4	6	
4	3876-061	SCREW, Phillips Head, 10-32 x 2-5/16 .....	2	2	—	
5	5503-045	WASHER, Flat .....	3	3	7	
6	5511-041	WASHER, Flat .....	2	2	2	
7	R-7200-426	GASKET, Scotch Foam Single Coated Black Vinyl Tape, 1/8" x 3/8" x 3 ft.	A/R	A/R	A/R	
8	10412-042	WASHER, Flat .....	4	4	—	
9	10585-041	SETSCREW, 10-32 x 1/4 .....	1	1	6	
10	11149-091	WASHER .....	4	2	4	
11	13320-091	RING, Retaining .....	2	2	2	
12	13796-045	SCREW, 3/8-16 x 1-1/2 .....	4	4	—	
13	15287-041	SCREW, Round Head, 10-32 x 1/2 .....	2	2	2	
14	15339-045	SCREW, Socket Head, 3/8-16 x 1-1/4 .....	7	7	7	
15	15361-042	SCREW, Round Head, 10-32 x 1/4 .....	3	3	1	
16	16383-045	SCREW, Socket Head, 3/8-16 x 1 .....	4	4	4	
17	16425-041	SCREW, Socket Head, 10-32 x 3/4 .....	3	3	3	
18	17589-045	WASHER .....	2	2	2	
19	19677-041	LOCKWASHER .....	14	12	11	
20	19678-045	LOCKWASHER .....	8	8	8	
21	19680-041	LOCKWASHER .....	15	15	21	
22	19688-045	LOCKWASHER .....	6	6	6	
23	20580-042	PLUG, Pipe .....	2	2	—	
24	31689-045	RING, Retaining .....	2	2	2	
25	41012-061	SCREW, Socket Head, 10-32 x 1/2 .....	5	3	6	
26	42566-091	PLUG, Pipe .....	2	2	—	
27	43237-091	SCREW, Socket Head .....	4	4	—	
28	43259-091	SCREW, Set, 6-32 x 3/16 .....	2	2	1	
29	43474-061	PISTON .....	1	1	1	
30	46124-056	SCREW, Flat Head, 1/4-20 x 3/4 .....	5	5	—	
31	48060-091	SCREW, Socket Head, 1/4-20 x 3/4 .....	1	1	—	
32	49134-061	WASHER, Flat .....	6	6	6	
33	52682-045	STOP, Elevator .....	1	1	—	
34	52718-091	SCREW, Socket Head, 1/4-20 x 2 .....	10	10	10	
35	52728-091	SUPPORT, Cover .....	1	1	1	
36	55130-010	BRACKET, Pump Mounting .....	1	1	1	
37	55131-010	ELEVATOR ASSEMBLY .....	1	—	—	
	136287-001	ELEVATOR ASSEMBLY .....	—	1	—	
38	55282-091	GASKET, Sump .....	1	1	1	
39	77525-045	SPACER .....	2	2	—	
40	77528-091	BEARING, Slide .....	2	2	—	
41	77590-061	PIN, Link .....	1	1	1	
42	78198-091	MANIFOLD .....	1	1	—	
*NOTE 1: 99424-001 used on units shipped before 2/71. 99424-001 deleted and parts transferred to 99936-001 on units shipped after 2/71. On units shipped after 1/75, some parts transferred from 99936-001 to 99388-001 and from 99929-002 to 99936-001.						

FIG & INDEX NO.		PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY		
Sheet 1 of 2						
8-28- 43		78216-045	SCREW, Cap Hex Head	6	6	6
44		78238-045	LEVER, Actuator	1	1	1
45		78239-045	SUPPORT, Cable	1	1	1
46		78240-091	SLIDE	1	1	1
47		78241-061	PIN	1	1	1
48		78242-042	BRACKET	1	1	1
49		78272-091	SPACER, Tube	1	1	—
50		78292-091	CONNECTOR, Male	1	1	—
51		78295-091	TEE, Union	1	1	—
52		78302-091	CLIP	1	1	1
53		78307-091	CABLE, Motor Start	1	1	1
54		78309-091	SPRING	1	1	1
55		78310-061	SLEEVE	1	1	1
56		78319-091	MOUNT, Motor	4	4	4
57		80925-061	CLAMP, Tube	1	1	—
58		81141-001	LABEL, Oil Specification	1	1	—
59		90513-091	CLIP, Tube	1	—	—
60		99309-091	PEDAL ASSEMBLY (See Fig. 8-37)	1	—	—
		146200-001	PEDAL ASSEMBLY (See Fig. 8-37)	—	1	1
61		†99323-002	FLOOR LOCK ASSEMBLY (See Fig. 8-40)	1	1	—
62		99388-002	PIPING ASSEMBLY (Not Shown — See Fig. 8-30)	1	1	—
63		99426-001	MOTOR AND PUMP ASSEMBLY (See Fig. 8-39)	1	—	—
		99426-002	MOTOR AND PUMP ASSEMBLY (See Fig. 8-38)	—	1	1
64		NLA	LIFT CYLINDER ASSEMBLY (Units Shipped Before 10/72)(See Fig. 8-34)	1	—	—
65		133636-001	TABLE SUPPORT ASSEMBLY (See Fig. 8-33)	1	1	—
66		133661-010	SUMP	1	1	1
67		133685-091	PUMP ASSEMBLY (See Fig. 8-31)	1	1	1
68		133690-091	COIL, Tubing	1	1	—
69		133699-001	DRIP PAN ASSEMBLY	1	—	—
		136243-001	DRIP PAN ASSEMBLY	—	1	1
70		NLA	LIFT CYLINDER ASSEMBLY (Units Shipped After 10/72) (See Fig. 8-35)	1	—	—
71		NLA	LIFT CYLINDER ASSEMBLY (Units Shipped After 1/75) (See Fig. 8-36)	1	1	—
71A		136375-001	LIFT CYLINDER ASSEMBLY (Units Shipped After 11/77)	1	1	—
Sheet 2 of 2						
72		3038-041	NUT, Hex (Units Shipped After 12/74)	2	2	—
73		R-7200	GASKET, Scotch Foam Single Coated Black Vinyl Tape, 1/4" x 1/4" x 7 ft. (Sub: 764317-529)	A/R	A/R	A/R
74		13084-045	SCREW, Self Tapping, 6x3/16	2	2	—
75		15324-042	SCREW, Round Head, 1/4-20 x 3/8 (Units Shipped After 12/74)	1	1	1
76		41535-010	SCREW, Flat Head (Units Shipped After 12/74)	2	—	—
77		44086-045	NUT, Speed, 1/4-20	4	4	4
78		46123-010	SCREW, Flat Head, 10-32 x 1/2	4	—	4
79		52718-091	SCREW, Socket Head, 1/4-20 x 2	4	4	—
80		76230-091	LOCKWASHER (Units Shipped After 12/74)	1	—	—
81		80220-061	CLIP, Shroud	2	2	—
82		80541-091	WIRE, Ground (Units Shipped After 12/74)	1	—	—
83		82312	RECEPTACLE, Ground (Units Shipped After 12/74) (Sub: 84964-091)	1	—	—
84		82439-001	BAR, Mounting (Units Shipped After 12/74)	1	—	—
85		90991-091	LOCKWASHER (Units Shipped After 12/74)	2	—	—
††NOTE 2: 99323-002 used on units shipped before 7/71. 99323-002 deleted and parts transferred to 99929-002, 134063-017, 134063-018, 134064-001 and 134064-002 on units shipped after 7/71. 99929-002 deleted and parts transferred to 99932-001 and 150128-001 on units shipped after 1/75.						

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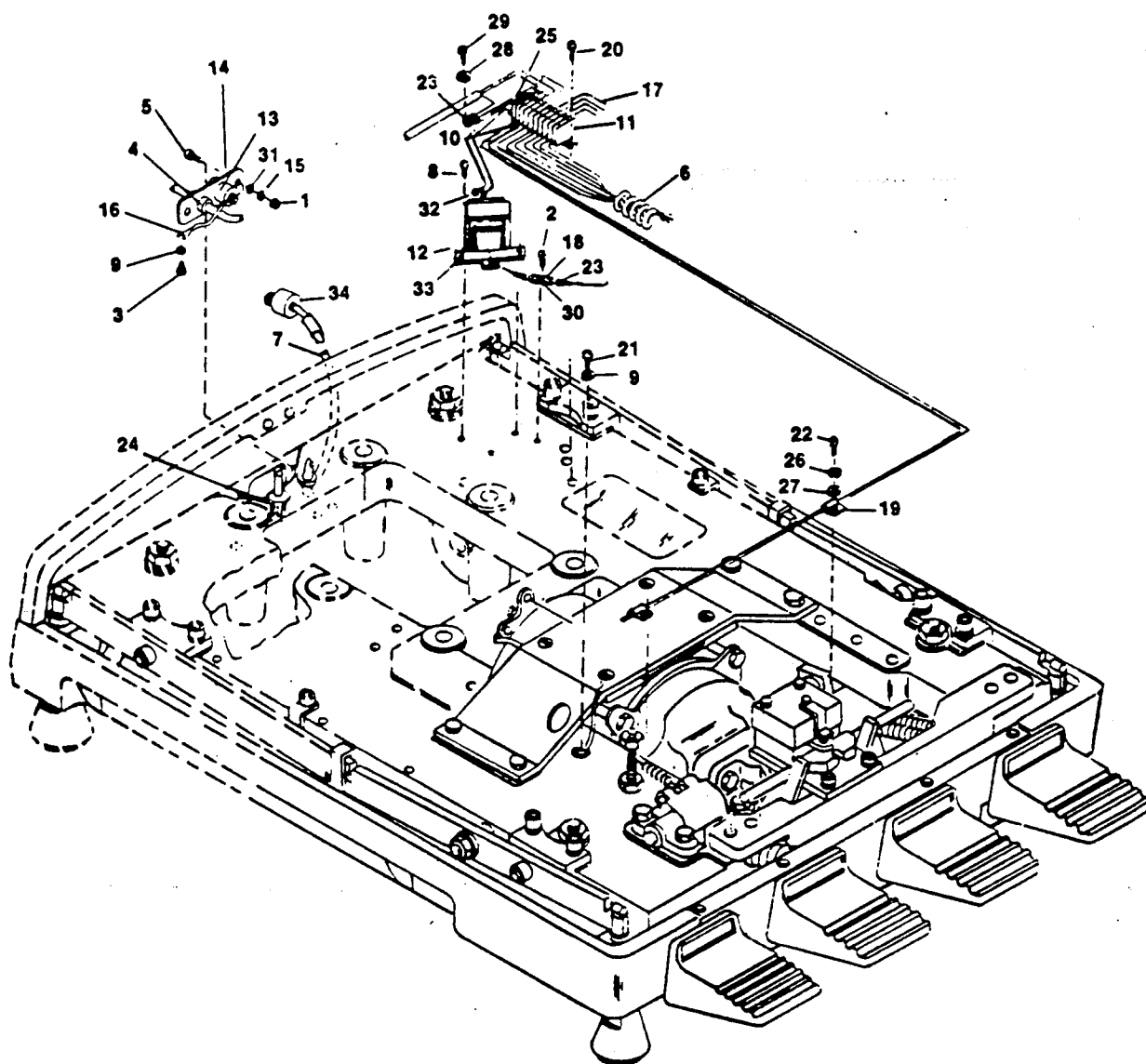


Figure 8-29. 2080RC BASE ELECTRIC COMPONENTS ASSEMBLY



FIG & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
8-29-	99047-091	2080RC BASE ELECTRIC COMPONENTS ASSEMBLY				
1	3038-041	NUT, Hex, 8-32 (Units Shipped After 12/74)	2			
2	3984-041	SCREW, Round Head, 6-32 x 5/8	1			
3	15324-042	SCREW, Round Head, 1/4-20 x 3/8 (Units Shipped After 12/74)	1			
4	30627-091	STRAIN, Relief (Units Shipped After 12/74)	1			
5	41535-010	SCREW, Flat Head, 8-32 x 3/4 (Units Shipped After 12/74)	2			
6		CORD, Coiled (See Fig. 8-6)	1			
7		CORD, 18 Ft. Long	1			
8	74307-061	SCREW, 8-32 x 3/8	2			
9	76230-091	LOCKWASHER, 1/4 (Units Shipped After 12/74)	3			
10	78047-091	BLOCK, Terminal Board	10			
11	78048-091	CAP, End, Terminal Board	1			
†12	56397-076	TRANSFORMER	1			
13	82312-001	RECEPTACLE, Ground (Units Shipped After 12/74)	1			
14	82332-001	BAR, Mounting (Units Shipped After 12/74)	1			
15	90991-091	LOCKWASHER, 8 (Units Shipped After 12/74)	2			
16	92491-001	WIRE, Ground (Units Shipped After 12/74)	1			
17	54670-091	CABLE ASSEMBLY	1			
18	150823-090	BLOCK, Fuse	1			
19	118153-091	CLAMP, Wire	3			
20	21711-042	SCREW, 5-40 x 7/16	2			
21	3969-041	SCREW, Round Head, 1/4-20 x 1/4	1			
22	9313-041	SCREW, Round Head, #10-32 x 5/16	2			
23	14592-091	TERMINAL	3			
24	91702-091	NIPPLE, Chase	1			
25	52724-091	WIRE ASSEMBLY	1			
26	17589-045	WASHER, Flat	2			
27	19677-041	WASHER, Lock	2			
28	76801-045	WASHER, Lock	2			
29	82675-001	GROUND SCREW, #10-32 x 3/8	2			
30	150823-091	FUSE	1			
31	150473-302	WASHER, Flat, #8	2			
32	118177-091	TERMINAL	2			
33	56397-077	BRACKET	1			
34	84498-001	PLUG	1			
	454201-001	• DECAL	AR			
	92615-002	• LABEL, 1 Amp	AR			
	80202-091	• TAG, Warning	AR			
		†NOTE: Old style transformer no longer available. Substitute kit P-764321-335.				

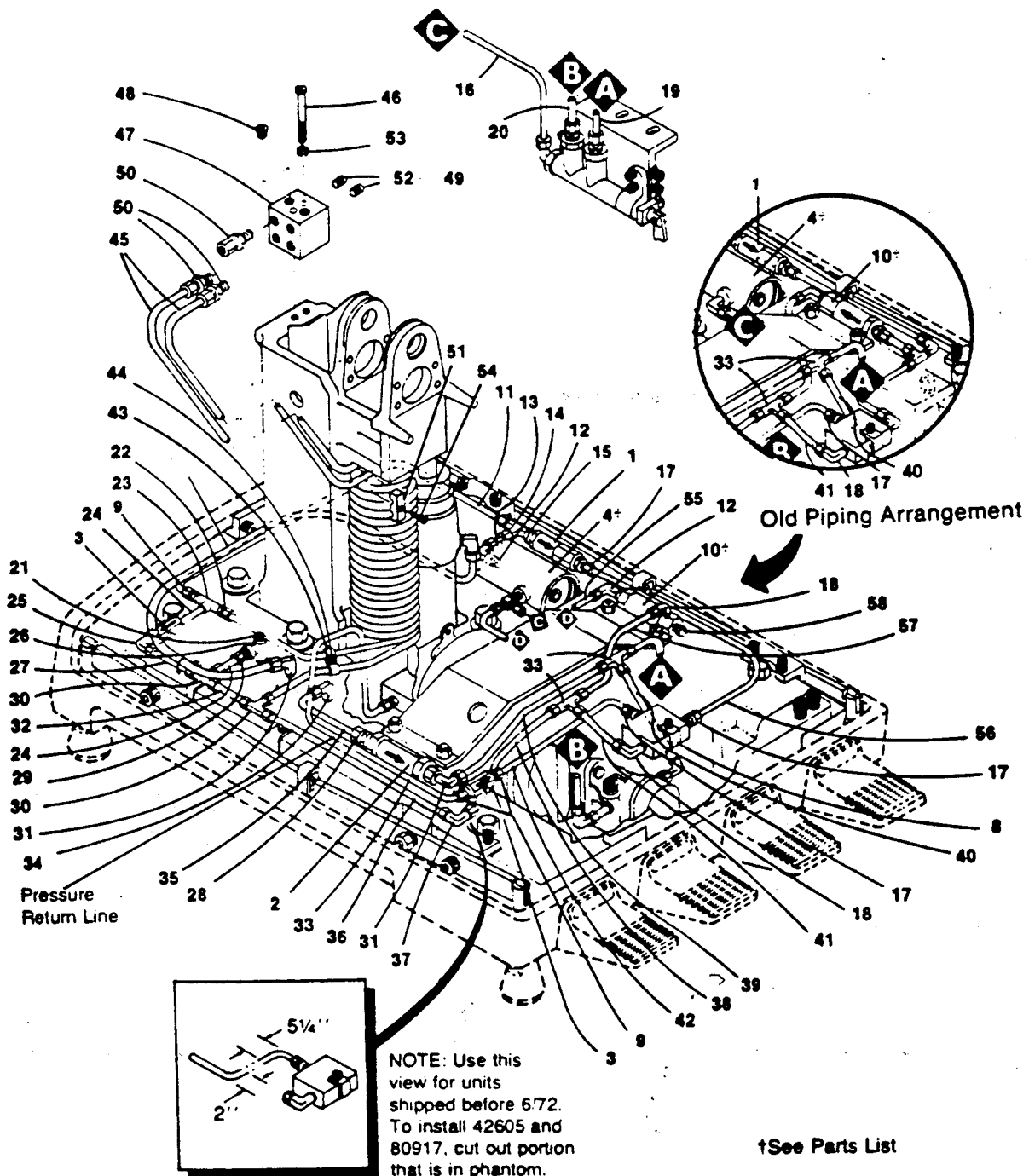


Figure 8-30. PIPING ASSEMBLY

FIG & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
8-30-	99388-001	2080L AND 2080 COMPAT PIPING ASSEMBLY .....	.	.		
	99388-002	2080RC PIPING ASSEMBLY .....	.	.		
1	42087-091	VALVE, Check .....	1	1		
2	42542-091	STRAINER .....	1	1		
3	42605-091	VALVE, Flow Control (One Required For Units Shipped Before 6/72) ..	2	2		
4	†56276-001	FILTER ASSEMBLY .....	1	1		
5	47208-091	• O-RING (Not Shown) .....	1	1		

FIG & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
8-30-	99388-001	2080L AND 2080 COMPAT PIPING ASSEMBLY .....	.	.		
	99388-002	2080RC PIPING ASSEMBLY .....	.	.		
	6	• FILTER, Oil (Not Shown) .....	1	1		
	7	• SEAL (Not Shown) .....	1	1		
	8	VALVE ASSEMBLY (See Fig. 8-37) .....	1	1		
	9	CONNECTOR, Male (One Required For Units Shipped Before 6/72) ...	3	3		
	10	† 80920-045 VALVE, Safety .....	1	1		
	11	78374-091 TUBE .....	1	1		
	12	52736-091 ELBOW, Male, 5/16 O.D.T. x 1/4 NPT .....	2	2		
	13	78373-091 TUBE .....	1	1		
	14	78289-091 TEE, Male Run, 5/16 ODT x 1/8 NPT .....	2	2		
	15	939-042 BUSHING, Reducing, 1/4 x 1/8 .....	1	1		
	16	78376-091 TUBE .....	1	1		
	17	52737-091 CONNECTOR, Male, 5/16 ODT x 1/4 NPT .....	3	3		
	18	46055-091 ELBOW, Male, 3/8 ODT x 1/4 NPT .....	2	2		
	19	78377-091 TUBE .....	1	1		
	20	81175-001 TUBE .....	1	1		
	21	5896-048 PLUG, Pipe, 3/8 NPT .....	1	1		
	22	80918-091 CONNECTOR, Male, 3/8 ODT x 1/8 NPT .....	1	1		
	23	42626-091 TEE, Pipe, 1/8 NPT .....	1	1		
	24	34779-091 NIPPLE, Brass, 1/8 NPT x 2-1/4 .....	1	1		
	25	80901-091 ELBOW, Male, 3/8 ODT x 1/8 NPT .....	1	1		
	26	78387-091 TEE, Street, 3/8 NPT .....	1	1		
	27	78368-091 TUBE .....	1	1		
	28	78293-091 CONNECTOR, Male, 3/8 ODT x 3/8 NPT .....	2	2		
	29	80916-091 TUBE .....	1	1		
	30	78295-091 TEE, Union, 3/8 ODT .....	4	4		
	31	45530-042 ELBOW, Male, 3/8 ODT x 3/8 NPT .....	2	2		
	32	78366-091 TUBE .....	1	1		
	33	56057-001 TUBE .....	1	1		
	34	78395-091 TUBE .....	1	1		
	35	78384-091 TUBE .....	1	1		
	36	78363-091 TUBE .....	1	1		
	37	52738-091 ELBOW, Union, 3/8 ODT .....	1	1		
	38	78367-091 TUBE .....	1	1		
	39	78383-091 TUBE .....	1	1		
	40	78364-091 TUBE .....	1	1		
	41	78365-091 TUBE .....	1	1		
	42	79907-001 TUBE .....	1	1		
	43	80925-061 CLAMP, Tube .....	1	1		
	44	48060-091 SCREW, Cap .....	1	1		
	45	133690-091 TUBE, Coil .....	1	1		
	46	3876-061 SCREW, Rd. Hd. ....	2	2		
	47	78198-091 MANIFOLD .....	1	1		
	48	42566-091 PLUG, Pipe .....	2	2		
	49	45565-091 CONNECTOR, Male .....	2	2		
	50	78292-091 CONNECTOR, Male .....	4	4		
	51	78272-091 SPACER, Tube .....	1	1		
	52	20580-042 PLUG, Pipe .....	2	2		
	53	19677-041 LOCKWASHER .....	2	2		
	54	46124-056 SCREW, Fl. Hd. ....	1	1		
	55	83622-001 TUBE, 5/16 OD .....	1	1		
	56	83621-001 TUBE, 5/16 OD .....	1	1		
	57	83623-001 TUBE, 3/8 OD .....	1	1		

† NOTE: If the filter is 3-3/4 inches long, order 56276-001 and reverse safety valve.  
Make changes as shown in Figure 7-4. Refer to paragraph 7-21.

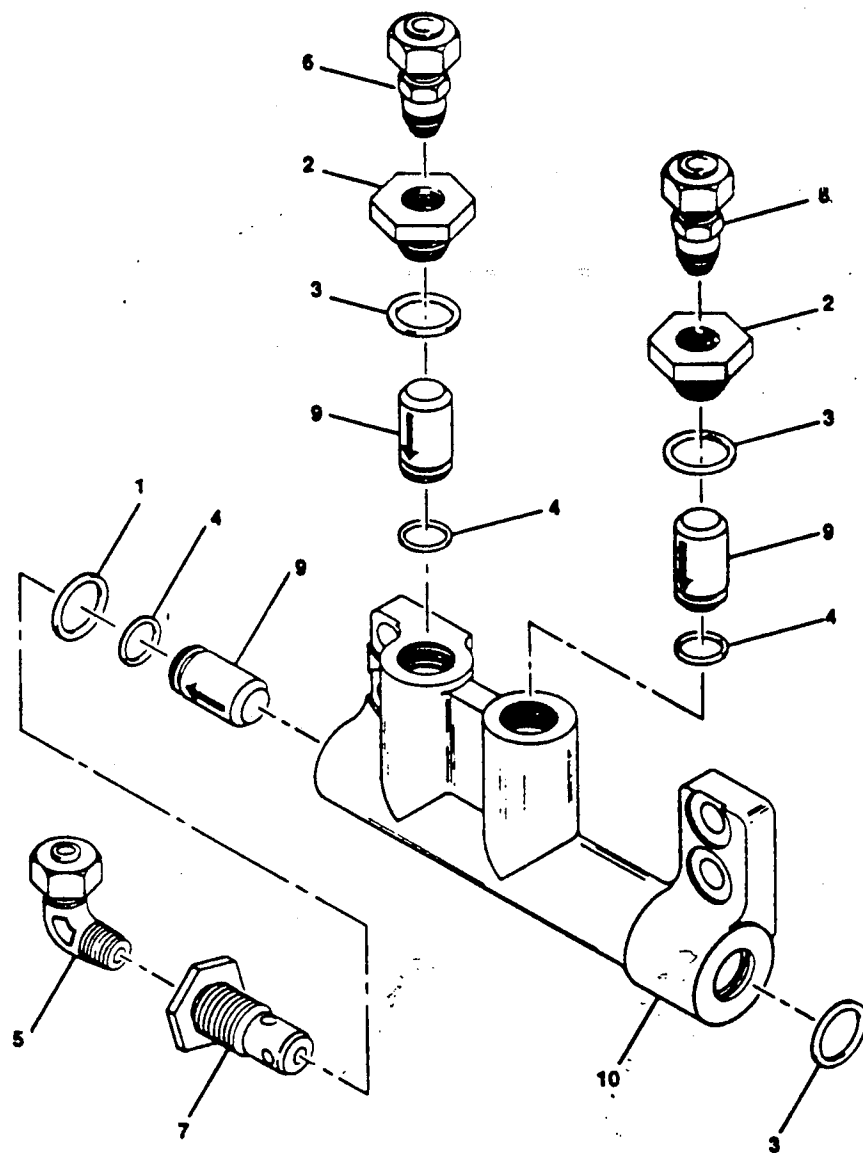


Figure 8-31. PUMP ASSEMBLY

<b>FIG &amp; INDEX NO.</b>	<b>PART NUMBER</b>	<b>DESCRIPTION</b>	<b>UNITS PER ASSEMBLY</b>			
8-31-	133685-091	PUMP ASSEMBLY				
1	7879-091	GASKET .....	1			
2	43478-091	CONNECTOR .....	2			
3	43489-091	O-RING .....	3			
4	45168-091	O-RING .....	3			
5	52736-091	ELBOW, Compression Fitting .....	1			
6	52737-091	CONNECTOR, Male .....	1			
7	78275-091	FITTING, Pump .....	1			
8	78292-091	FITTING, Straight Compression .....	1			
9	56397-051	VALVE, Check .....	3			
10	133662-010	BODY, Pump .....	1			

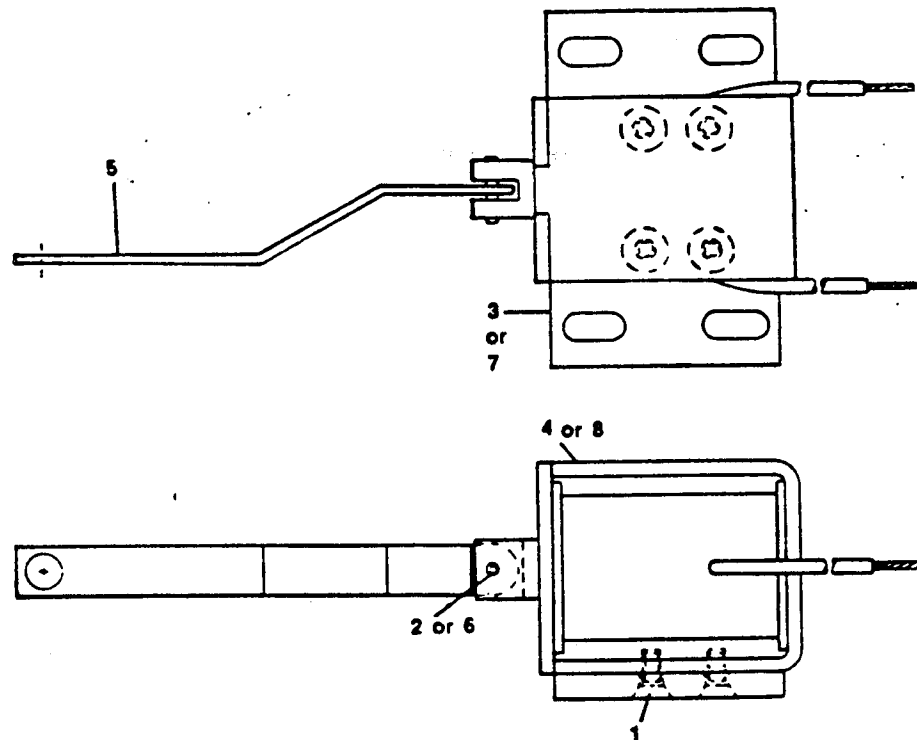
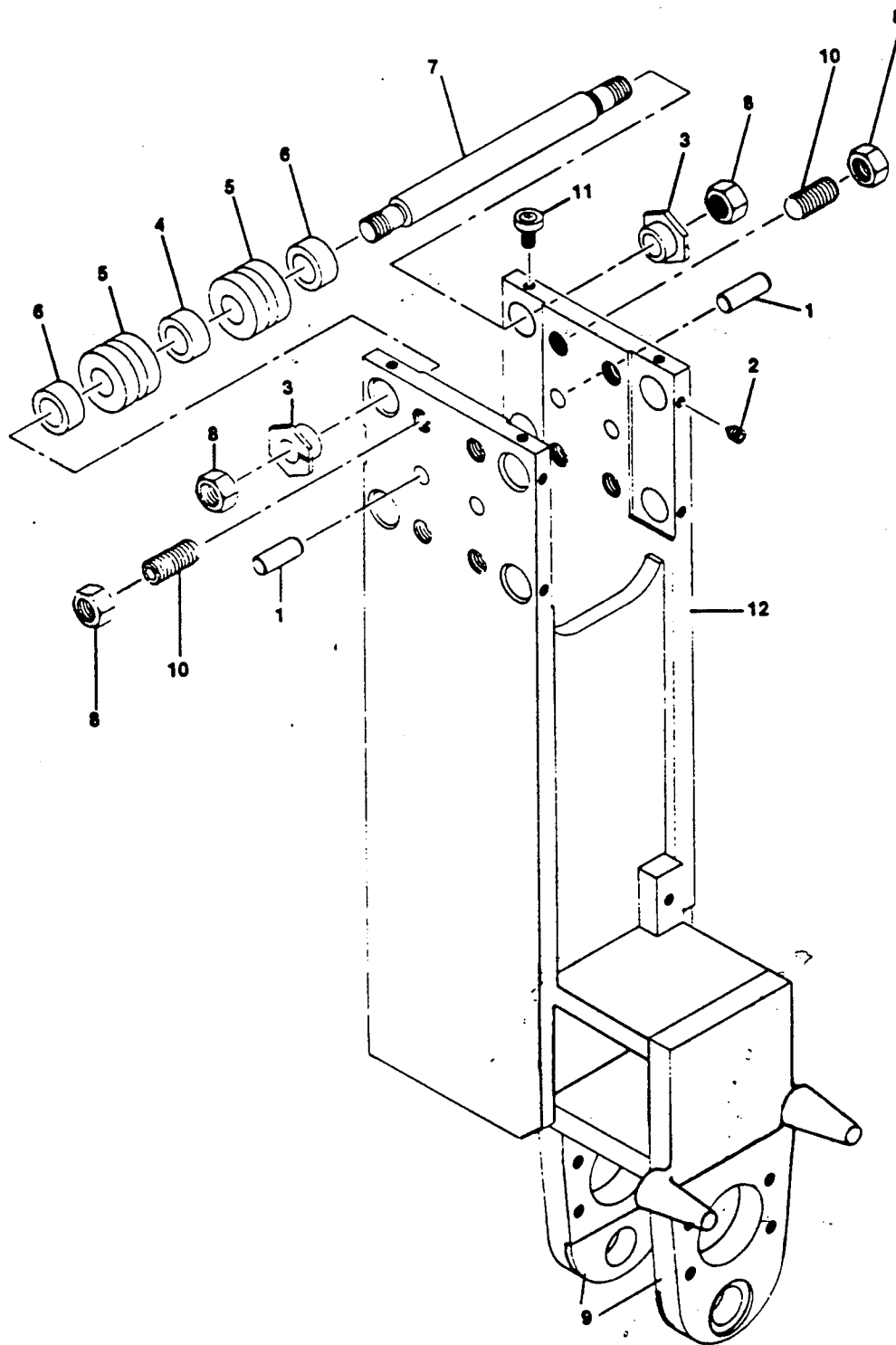


Figure 8-32. 2080RC SOLENOID ASSEMBLY

FIG & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
8-32-	77717-091	2080RC SOLENOID ASSEMBLY (Units Shipped Before 9/81) .....	X			
	56397-009	2080RC SOLENOID ASSEMBLY (Units Shipped After 9/81) .....		X		
	1	4617-041	SCREW, Flat Head, 8-32 x 3/8 .....	4	4	
	2	45591-061	PIN, Roll .....	1		
	3	77700-045	PLATE, Mounting .....	1		
	4	81008-091	SOLENOID NLA .....	1		
	5	81012-045	LEVER .....	1	1	
	6	3185-041	PIN, Cotter .....		1	
7	77700-001	PLATE, Mounting .....		1		
8	56397-010	SOLENOID .....		1		



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Figure 8-33. TABLE SUPPORT ASSEMBLY



FIG & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
8-33-	133636-001	TABLE SUPPORT ASSEMBLY				
1	16250-091	PIN, Dowel .....	4			
2	43223-091	SETSCREW, 10-32 x 1/4 .....	8			
3	46478-091	CAM, Loading .....	8			
4	46485-045	SPACER .....	4			
5	46572-091	BEARING .....	8			
6	77526-045	SPACER .....	8			
7	77527-091	SHAFT, Bearing .....	4			
8	150823-073	LOCKNUT, Jam 1/2-20 with Nylon Insert .....	16			
9	79781-001	PLATE, Wear .....	2			
10	80116-042	SETSCREW, 1/2-20 x 1 .....	8			
11	90383-091	BUMPER, Rubber .....	4			
12	99417-001	CASTING, Support .....	1			

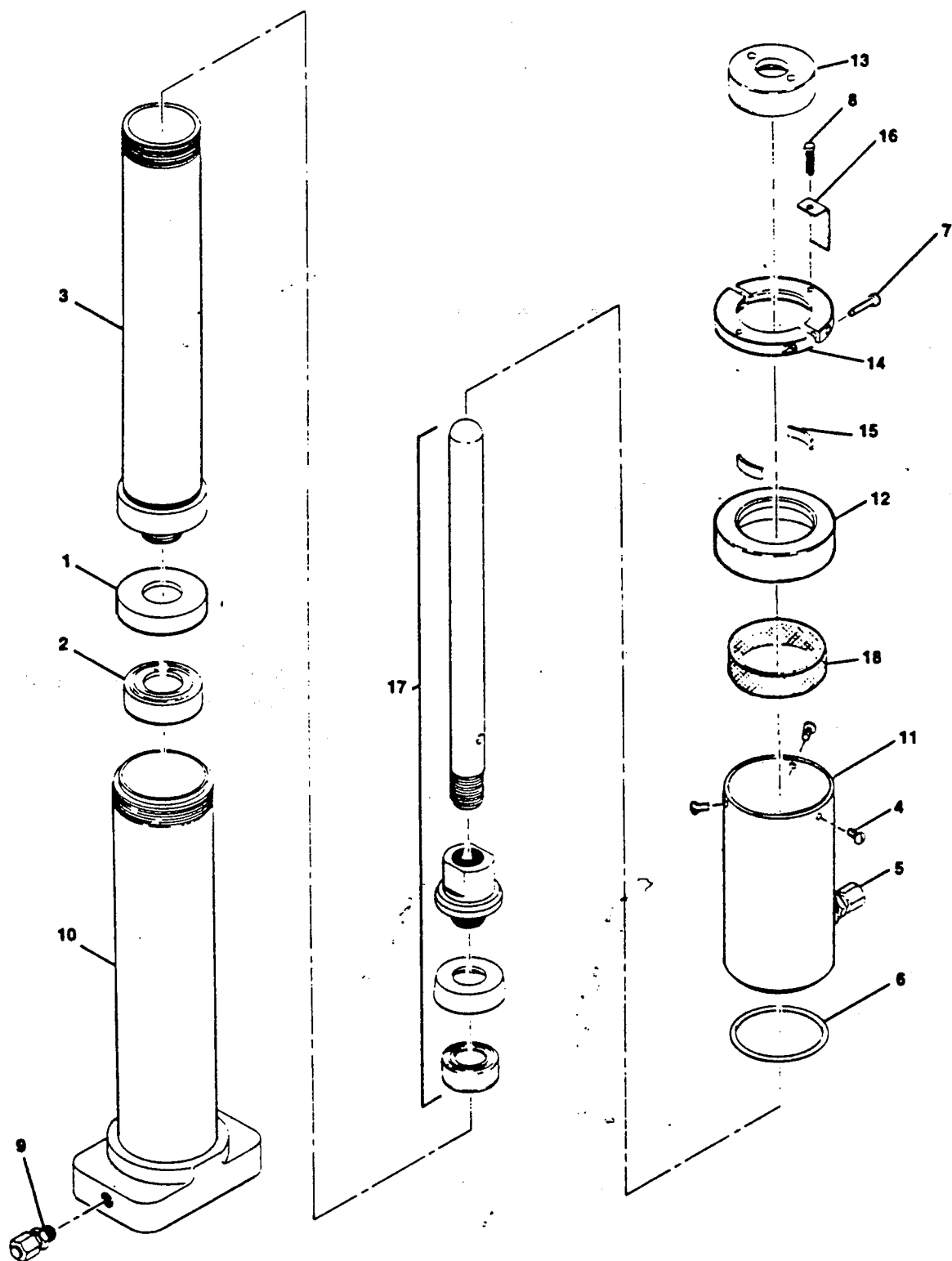
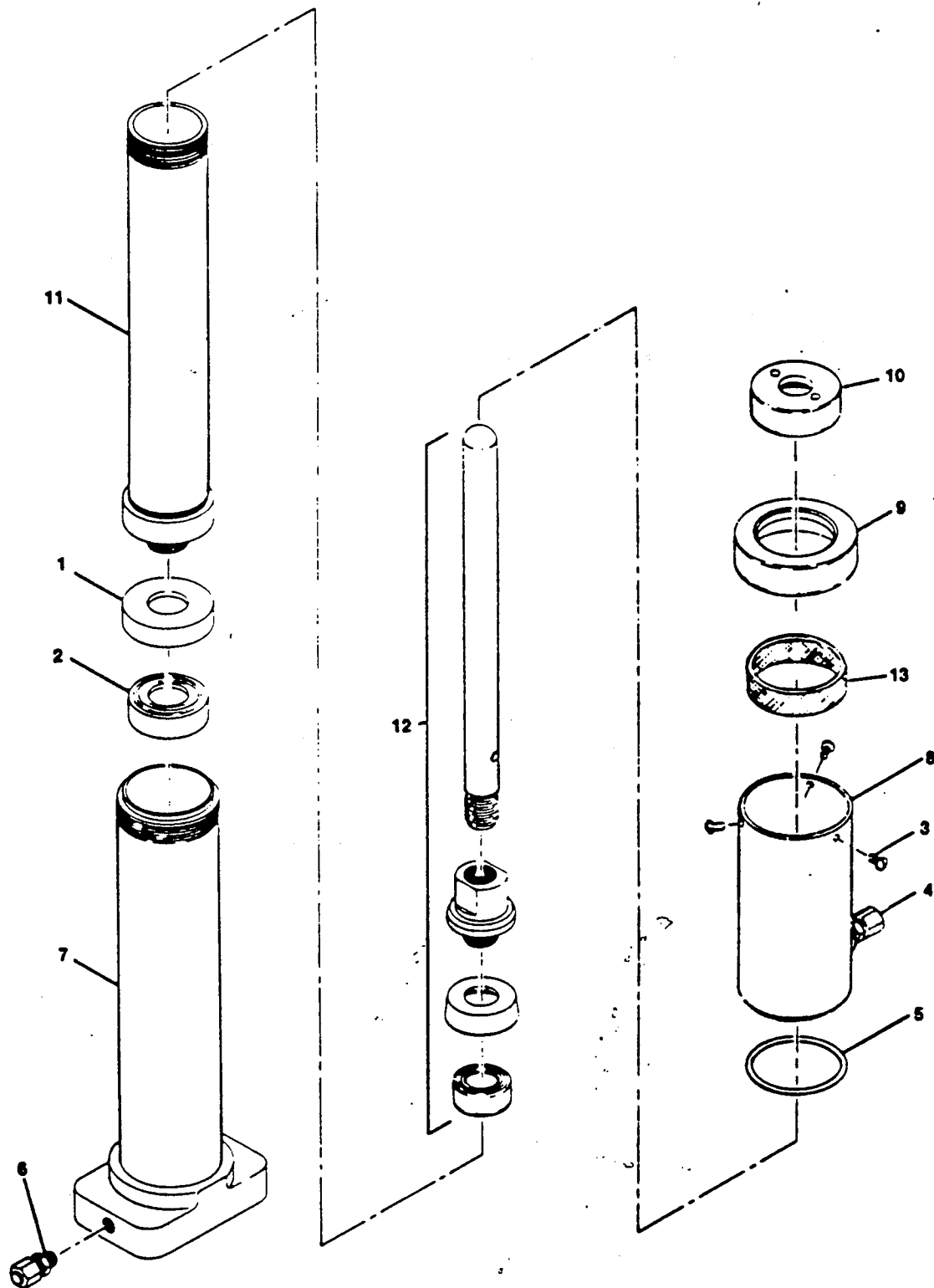


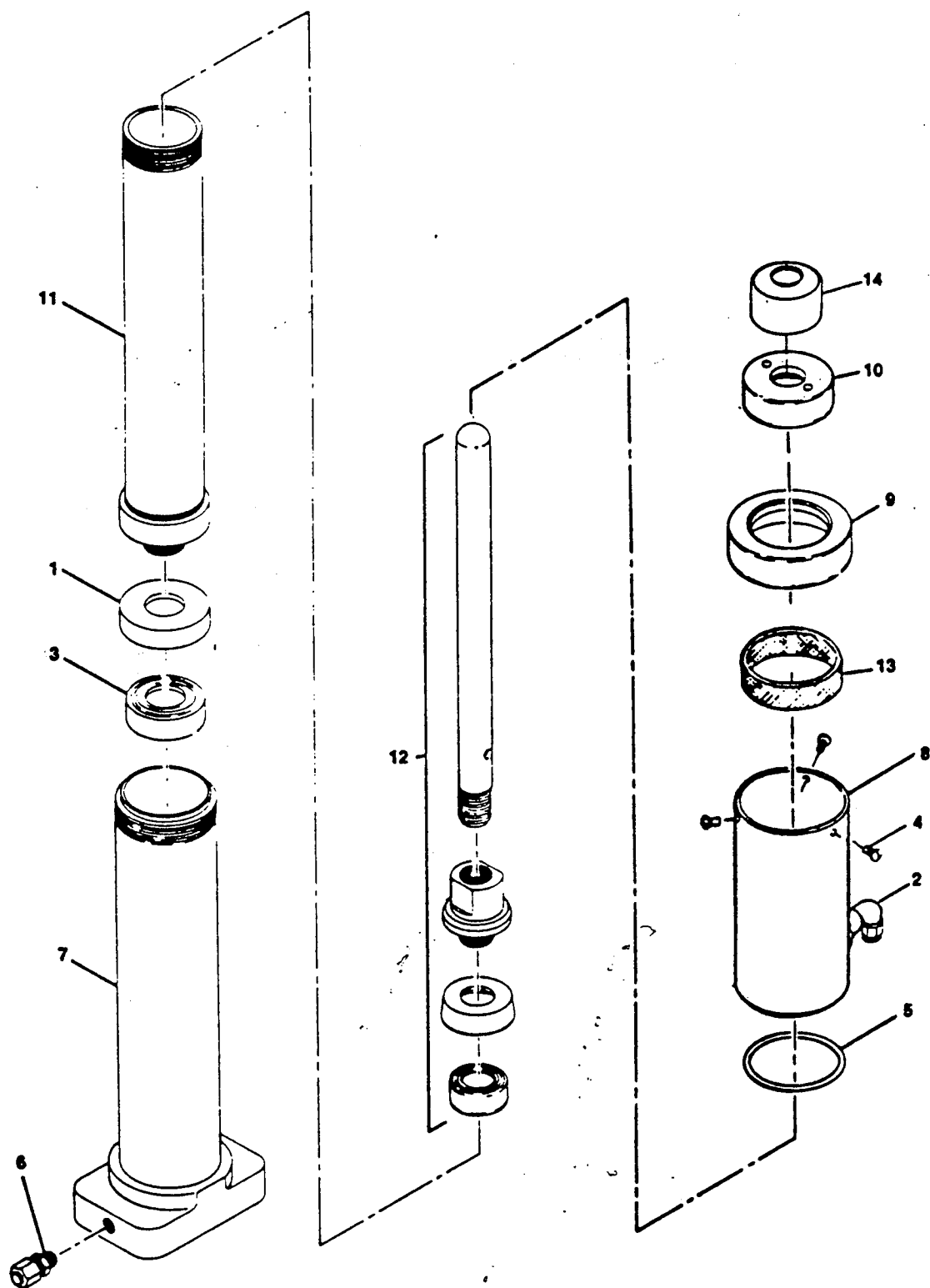
Figure 8-34. LIFT CYLINDER ASSEMBLY; UNITS SHIPPED BEFORE 10/72.

FIG & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
8-34-	NLA	LIFT CYLINDER ASSEMBLY (Units Shipped Before 10/72) (+133634)	X			
1		CUP, Leather, Large .....	1			
2		NUT, Piston .....	1			
3		CYLINDER ASSEMBLY .....	1			
4		SCREW, Pan Head .....	3			
5		CONNECTOR, Male .....	1			
6		O-RING .....	1			
7		SCREW, Socket Head .....	2			
8		SCREW, Flat Head .....	2			
9		CONNECTOR, Male .....	1			
10		OUTER CYLINDER ASSEMBLY .....	1			
11		SLEEVE WELDMENT .....	1			
12		CAP, Large Cylinder .....	1			
13		CAP, Small Cylinder .....	1			
14		RING, Split .....	1			
15		STRIP, Leather .....	2			
16		RING, Retainer .....	2			
17		SMALL PISTON ASSEMBLY .....	1			
18		WOOL, Monel .....	A/R			
†Note: 133634-001 is replaced by new lift cylinder 136375-001.						



**Figure 8-35. LIFT CYLINDER ASSEMBLY; UNITS SHIPPED AFTER 10/72 BUT BEFORE 1/75.**

FIG & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
8-35-	NLA	LIFT CYLINDER ASSEMBLY (Units Shipped After 10/72 But Before 1/75) ( + 135940) .....	X			
1		CUP, Leather, Large .....	1			
2		NUT, Piston .....	1			
3		SCREW, Pan Head, 6-32 x 1/4 .....	3			
4		CONNECTOR, Male .....	1			
5		O-RING .....	1			
6		CONNECTOR, Male .....	1			
7		CYLINDER ASSEMBLY .....	1			
8		SLEEVE WELDMENT .....	1			
9		CAP, Large Cylinder .....	1			
10		CAP, Small Cylinder .....	1			
11		LARGE PISTON ASSEMBLY .....	1			
12		SMALL PISTON ASSEMBLY .....	1			
13		WOOL, Monel .....	A/R			
		 +Note: 135940-001 is replaced by new lift cylinder 136375-001.				



**Figure 8-36. LIFT CYLINDER ASSEMBLY; UNITS SHIPPED BETWEEN 1/75 AND 7/77.**

FIG & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
8-36-	NLA	LIFT CYLINDER ASSEMBLY (Units Shipped Between 1/75 and 7/77) ( † 135940) .....	X			
1		CUP, Leather, Large .....	1			
2		ELBOW, Male .....	1			
3		NUT, Piston .....	1			
4		SCREW, Pan Head, 6-32 x 1/4 .....	3			
5		O-RING .....	1			
6		CONNECTOR, Male .....	1			
7		CYLINDER ASSEMBLY .....	1			
8		SLEEVE WELDMENT .....	1			
9		CAP, Large Cylinder .....	1			
10		CAP, Small Cylinder .....	1			
11		LARGE PISTON ASSEMBLY .....	1			
12		SMALL PISTON ASSEMBLY .....	1			
13		WOOL, Monel .....	A/R			
14		SPLASH CUP ASSEMBLY .....	1			
		† Note: 135940-002 is replaced by new lift cylinder 136375-001.				

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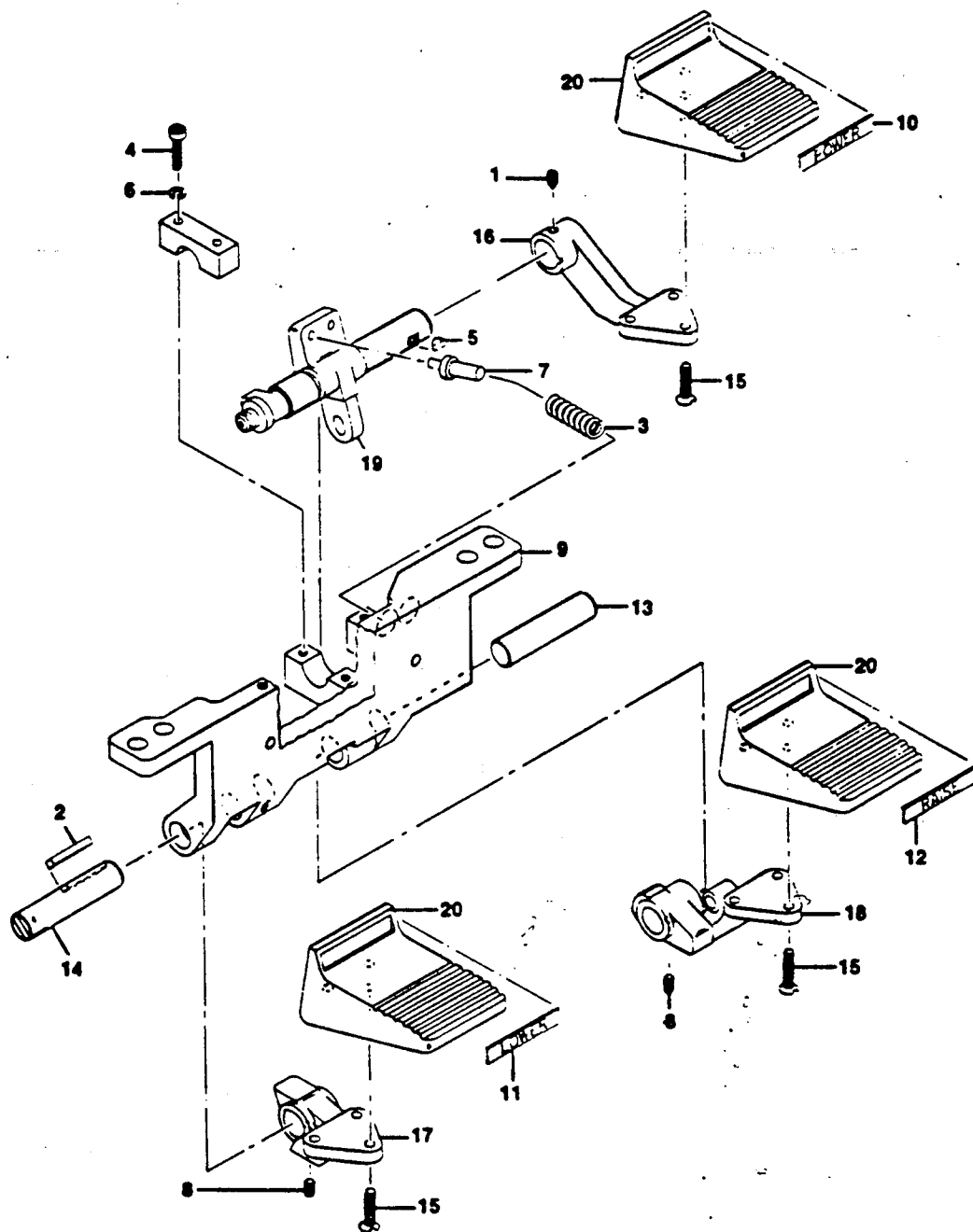


Figure 8-37. PEDAL ASSEMBLY (Sheet 1 of 2)



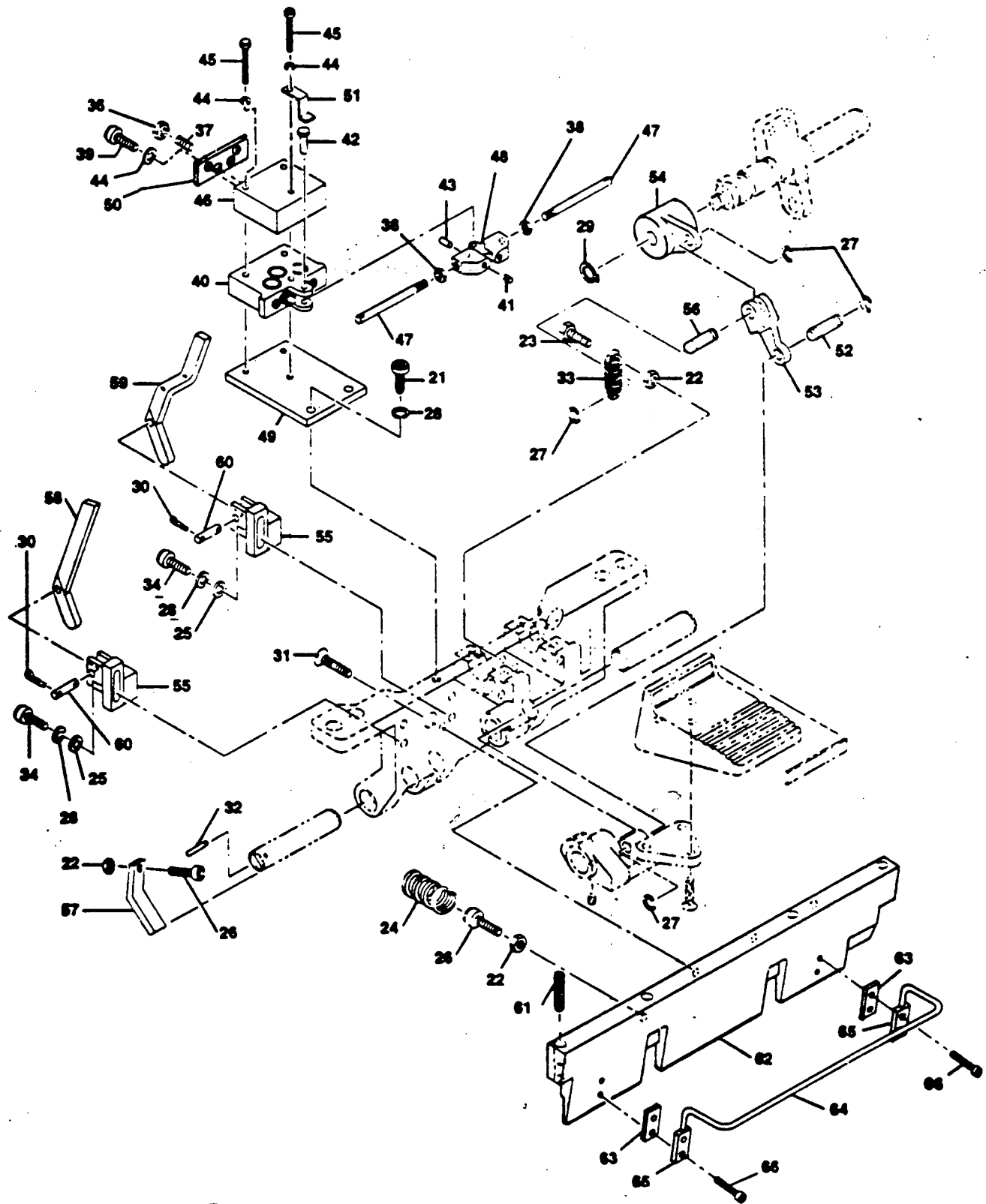
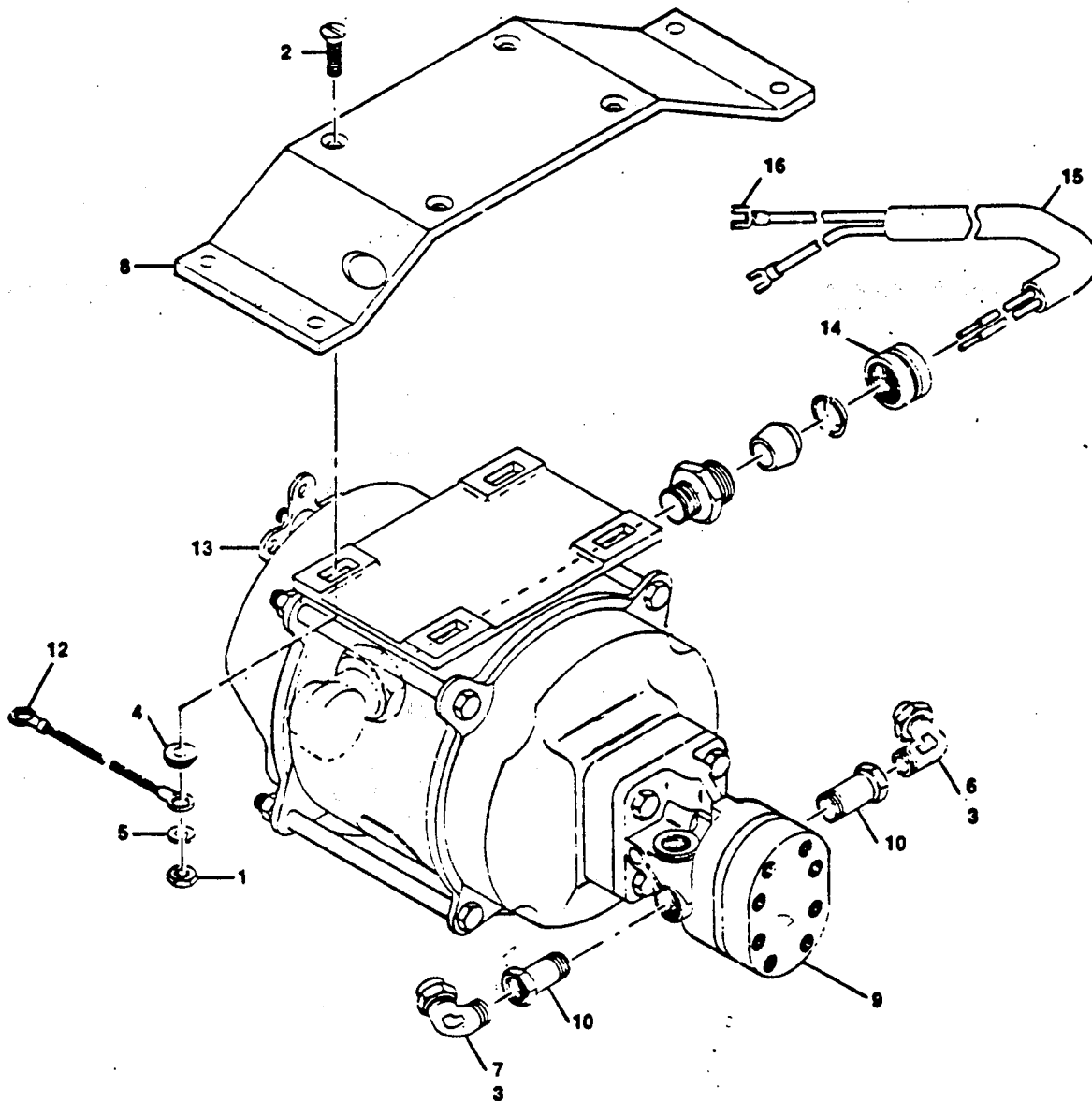


Figure 8-37. PEDAL ASSEMBLY (Sheet 2 of 2)

FIG & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
8-37-	99309-091	PEDAL ASSEMBLY — 2080L AND 2080RC .....	X			
	146200-001	PEDAL ASSEMBLY — 2080 COMPAT IV .....		X		
		Sheet 1 of 2				
1	4772-045	SETSCREW, Cup Point, 1/4-20 x 1/4 .....	1	1		
2	12704-091	KEY .....	1	1		
3	15124-091	SPRING .....	2	2		
4	15339-045	SCREW, Socket Head .....	2	2		
5	16261-091	KEY .....	2	2		
6	19678-045	LOCKWASHER .....	2	2		
7	22894-091	RETAINER .....	2	2		
8	40006-061	SETSCREW, 1/4-20 x 5/16 .....	3	3		
9	55117-010	SUPPORT, Pedal .....	1	1		
10	55284-001	NAMEPLATE — "POWER" .....	1	1		
11	55284-002	NAMEPLATE — "LOWER" .....	1	1		
12	55284-003	NAMEPLATE — "RAISE" .....	1	1		
13	77594-061	PIN, Pedal .....	1	1		
14	77720-061	PIN .....	1	1		
15	79539-010	SCREW, Flat Head, 10-24 x 5/8 .....	9	9		
16	133650-010	ARM, Power .....	1	1		
17	133651-010	ARM, Lower .....	1	1		
18	133652-010	ARM, Raise .....	1	1		
19	133686-091	ACTUATOR .....	1	1		
20	133687-010	PEDAL, Cast .....	3	3		
		Sheet 2 of 2				
21	2792-045	SCREW, Socket, 1/4-20 x 1/2 .....	2	2		
22	3097-041	NUT, Hex .....	3	3		
23	3848-051	SCREW, 1/4-20 x 3/4 .....	1	1		
24	4283-095	SPRING .....	1	1		
25	11149-091	WASHER .....	4	4		
26	11266-045	SCREW, Socket Head, 1/4-20 x 1 .....	2	2		
27	13320-091	RING, Retaining .....	4	4		
28	19678-045	LOCKWASHER .....	6	6		
29	31820-091	RING, Retaining .....	1	1		
30	32269-091	PIN, Cotter .....	4	4		
31	150823-064	SCREW, Flat Head, 1/4-20 x 1 .....	3	3		
32	43308-061	PIN, Roll .....	1	1		
33	46225-061	SPRING .....	1	1		
34	48060-091	SCREW, Socket, 1/4-20 x 3/4 .....	4	4		
35		NOT USED				

FIG & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
Sheet 2 of 2						
8-37-	55278-091	VALVE ASSEMBLY (Includes items 36 thru 51) (See Fig. 8-30) .....	1	1		
36	2960-042	• NUT, 10-32 .....	2	2		
37	10584-041	• SETSCREW, 10-32 x 1/2 .....	2	2		
38	24987-041	• NUT, Hex, 1/4-20 .....	2	2		
39	41012-061	• SCREW, Cap .....	2	2		
40	+42563	• VALVE, Gabriel (Sub: 134469-008) .....	1	1		
41	150823-002	• SETSCREW, 1/4-48 x 5/8 .....	2	2		
42	43294-061	• PIN .....	1	1		
43	44603-061	• PLUG .....	2	2		
44	46115-091	• LOCKWASHER, 10 .....	3	3		
45	46163-091	• SCREW, Cap, 10-32 x 2 .....	3	3		
46	55277-091	• PLATE, End .....	1	1		
47	77634-045	• ROD, Connecting .....	2	2		
48	78199-001	• LEVER, Valve .....	1	1		
49	78250-010	• PLATE, Mounting .....	1	1		
50	79717-091	• PLATE, Retaining .....	1	1		
51	80700-061	• RETAINER, Pin .....	1	1		
52	77591-061	PIN, Link .....	1	1		
53	77596-091	LINK, Connecting .....	1	1		
54	77597-091	LINK, Power .....	1	1		
55	77718-001	BRACKET .....	2	2		
56	77742-061	PIN, Link .....	1	1		
57	78210-061	LEVER, Power .....	1	1		
58	78231-042	LEVER, Lower .....	1	1		
59	78232-042	LEVER, Raise .....	1	1		
60	78236-061	PIN, Retaining .....	2	2		
61	79593-001	SETSCREW .....	4	4		
62	133682-010	PLATE, Front .....	1			
	93268-001	PLATE, Front .....		1		
63	83994-002	SHIM .....		A/R		
64	93425-001	BAR, Guard .....		1		
65	84478-001	BLOCK, Guard .....		2		
66	150801-001	SCREW, Socket Head, 10-32 x 1-1/4 .....		4		



**Figure 8-38. 2080RC AND 2080 COMPAT IV MOTOR AND PUMP ASSEMBLY.**

**†SEE PARTS LIST FOR IMPORTANT NOTE.**

FIG & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
8-38-	99426-002	2080RC AND 2080 COMPAT IV MOTOR AND PUMP ASSEMBLY				
1	3097-041	NUT, Hex .....	4			
2	3948-041	SCREW, Flat Head, 1/4-20 x 3/4 .....	4			
3	R-5300-600	SEALING COMPOUND .....	A/R			
4	5473-041	WASHER, Bevel .....	4			
5	19678-045	WASHER, Lock .....	4			
6	46055-091	ELBOW, Male .....	1			
7	52736-091	ELBOW, Male .....	1			
8	55128-010	PLATE, Mounting .....	1			
9	759206-001	PUMP .....	1			
10	78282-091	ADAPTER .....	2			
11	79854-001	PLUG (Not Shown) .....	1			
12	80541-091	WIRE, Ground .....	1			
13	+134069-001	MOTOR AND PUMP .....	1			
14	34111-091	CONNECTOR .....	1			
15	3500-150	TUBE, Tygon .....	1			
16	118178-091	TERMINAL .....	3			
<p>+NOTE 1: Do not break seal on pump, motor and box unit. The unit must be returned to factory for servicing.</p>						

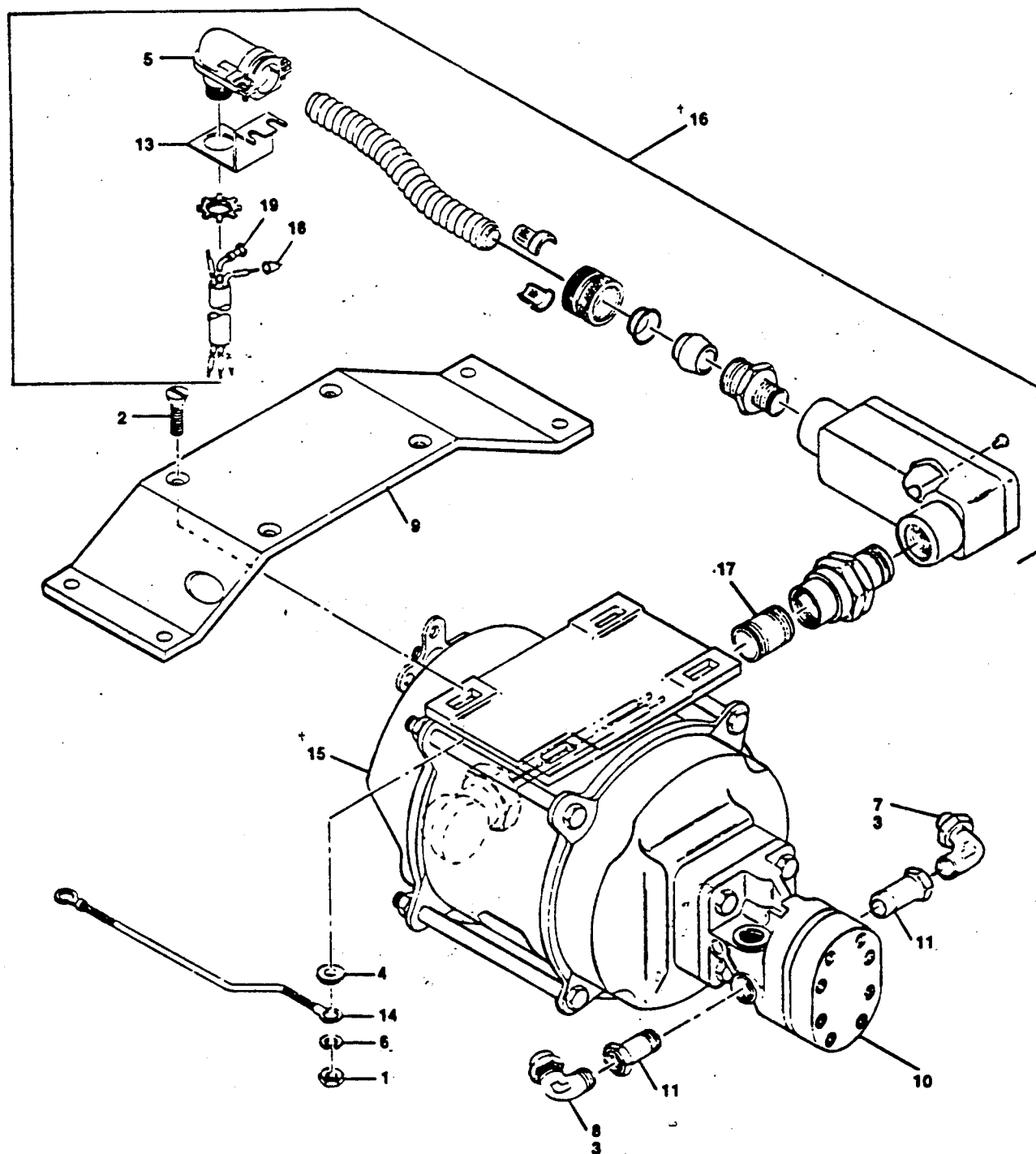


Figure 8-39. 2080L MOTOR AND PUMP ASSEMBLY

†SEE PARTS LIST FOR IMPORTANT NOTES.

FIG & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
8-39-	99426-001	2080L MOTOR AND PUMP ASSEMBLY				
1	3097-041	NUT, Hex .....	4			
2	3948-041	SCREW, Flat Head, 1/4-20 x 3/4 .....	4			
3	R-5300-600	SEALING COMPOUND .....	A/R			
4	5473-041	WASHER, Bevel .....	4			
5	18001-091	CONNECTOR, Box .....	1			
6	19678-045	LOCKWASHER .....	4			
7	46055-091	ELBOW, Male .....	1			
8	52736-091	ELBOW, Male .....	1			
9	55128-010	PLATE, Mounting .....	1			
10	759206-001	PUMP .....	1			
11	78282-091	ADAPTER .....	2			
12	†† 79804-001	PLUG (not shown) .....	1			
13	80103-061	BRACKET, Mounting .....	1			
14	80541-091	WIRE, Ground .....	1			
15	†134069-001	MOTOR AND PUMP .....	1			
16	†136350-001	CORD AND BOX ASSEMBLY .....	1			
17	82985-001	CONDUIT, Rigid .....	1			
18	18538-091	CONNECTOR .....	2			
19	118178-091	TERMINAL .....	1			
<p>†NOTE 1: Do not break seal on pump, motor and box unit. The unit must be returned to factory for servicing. The cord and box assembly can be replaced in field. See instructions in paragraph 7-23.</p> <p>††NOTE 2: Do not remove plug. If plug is removed, AMSCO's warranty is voided and Table no longer meets UL safety standards.</p>						

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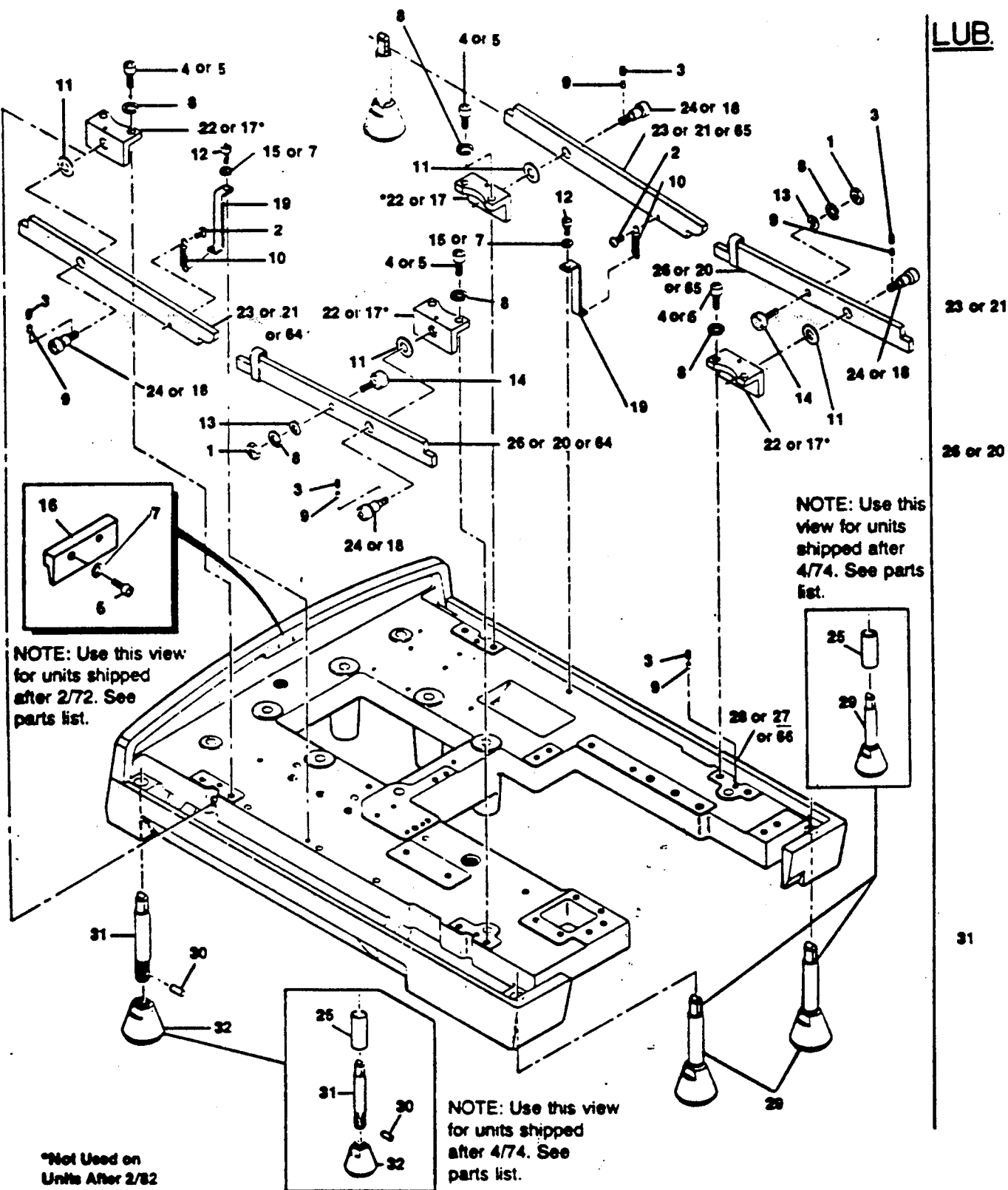


Figure 8-40. FLOOR LOCK ASSEMBLY (Sheet 1 of 2)



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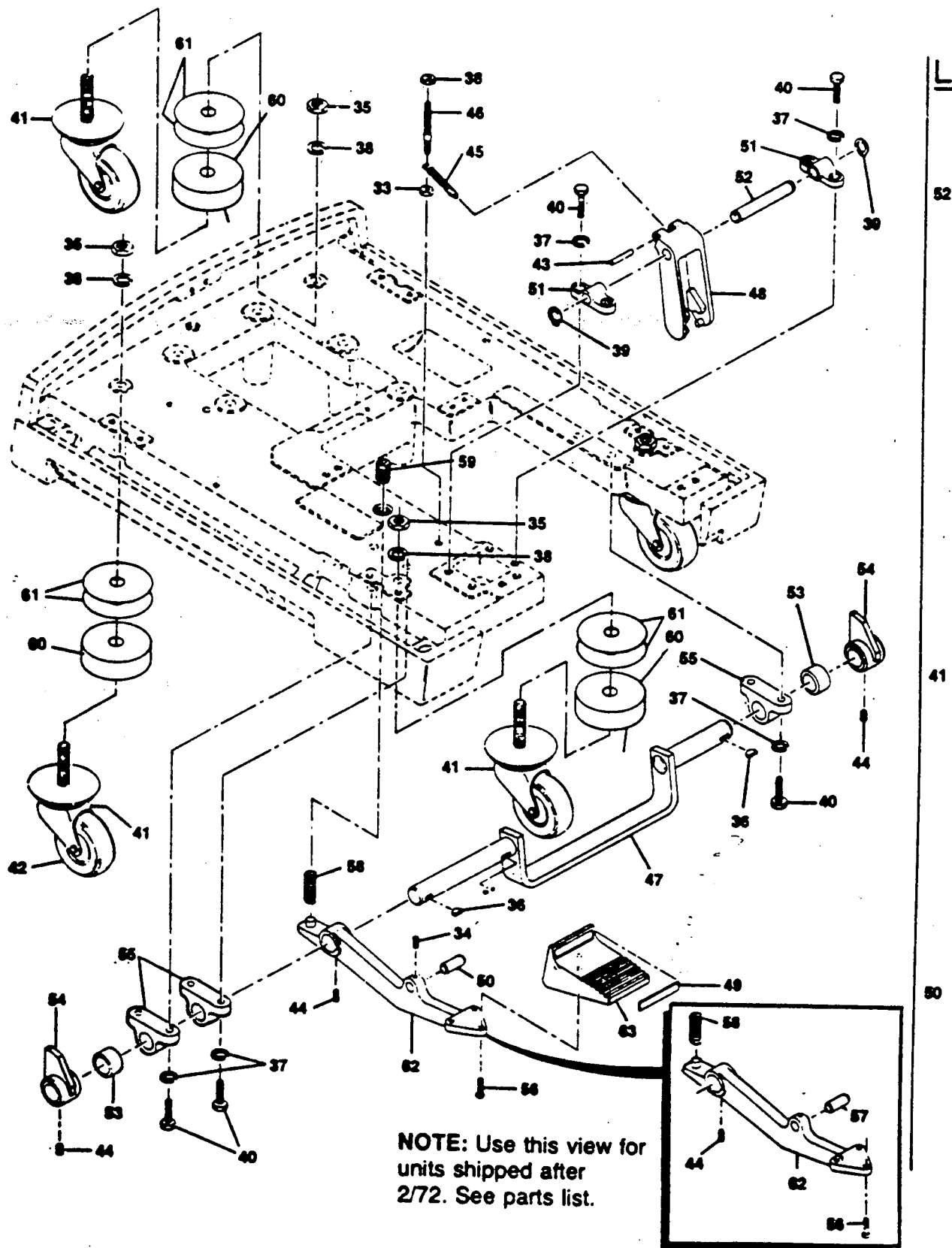


Figure 8-40. FLOOR LOCK ASSEMBLY (Sheet 2 of 2)

FIG & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
8-40-		FLOOR LOCK ASSEMBLY — 2080L (Units Shipped After 2/82)			X	
		FLOOR LOCK ASSEMBLY — 2080L AND 2080RC (Units Shipped Before 2/82)	X			
		FLOOR LOCK ASSEMBLY — 2080 COMPAT		X		
		Sheet 1 of 2				
1	2945-041	NUT, Hex .....	2	2	2	
2	9374-041	SCREW, Round Head, 10-32 x 3/8 .....	2	2	2	
3	10585-041	SETSCREW, 10-32 x 1/4 .....	4	4	4	
4	12439-045	SCREW, Socket Head, 3/8-16 x 3/4 (Units Shipped Before 2/72) .....	8	—	—	
5	16383-045	SCREW, Socket Head (Units Shipped After 2/72) .....	8	8	—	
6	16425-041	SCREW, Socket Head, 10-32 x 3/4 (Units Shipped After 2/72) .....	2	2	2	
7	19677-041	LOCKWASHER (Units Shipped After 2/72) .....	4	4	4	
8	19680-041	LOCKWASHER .....	10	10	10	
9	22436-091	PLUG, Nylon .....	4	4	4	
10	24833-061	SPRING .....	2	2	2	
11	34510-091	WASHER, Nylon .....	4	4	4	
12	41012-061	SCREW, Socket, 10-32 x 1/2 .....	2	2	2	
13	43754-045	WASHER, Flat .....	2	2	2	
14	45272-091	BEARING .....	2	2	2	
15	46115-091	LOCKWASHER (Units Shipped Before 2/72) .....	2	—	—	
16	52728-091	SUPPORT, Cover (Units Shipped After 2/72) .....	1	1	1	
17	††77652-045	BRACKET, Floor Lock Mounting (Units Shipped Before 7/73) .....	4	—	—	
18	††77722-042	SCREW, Shoulder (Units Shipped Before 7/73) .....	4	—	4	
19	77723-061	SUPPORT .....	2	2	2	
20	††77725-045	GUIDE, Floor Lock (Units Shipped Before 7/73) .....	2	—	—	
21	††77727-045	BAR, Floor Lock (Units Shipped Before 7/73) .....	2	—	—	
22	82477-001	BRACKET, Floor Lock Mounting (Units Shipped After 7/73) .....	4	4	—	
23	82479-001	BAR, Floor Lock (Units Shipped After 7/73) .....	2	2	—	
24	82481	SCREW, Shoulder (Units Shipped After 7/73) (Sub: 77722-042) .....	4	4	—	
25	†82633-001	BEARING, Sleeve, Oilite (Units Shipped After 4/74) .....	4	4	4	
26	92524-001	GUIDE, Floor Lock (Units Shipped After 7/73) .....	2	2	—	
27	99320-010	BASE (Units Shipped After 1/75) .....	1	1	—	
28	99387-010	BASE (Units Shipped Before 1/75) .....	1	—	—	
29	150202-001	PIN AND FOOT ASSEMBLY (Includes 21504, 41503 and 150199) .....	4	—	—	
	83748-001	PIN AND FOOT ASSEMBLY (Includes 21504, 83747 and 150199) .....	—	4	4	
30	21504-091	• CYLINDER, Rubber .....	4	4	4	
31	41530-045	• PIN ASSEMBLY .....	4	—	4	
	83747-001	• PIN ASSEMBLY .....	—	4	—	
32	150199-001	• FOOT .....	4	4	4	
		†NOTE 1: 99323-002 used on units shipped before 7/71. 99323-002 deleted and parts transferred to 99929-002, 134063-017, 134063-018, 134064-001 and 134064-002 on units shipped after 7/71. 99929-002 deleted and parts transferred to 99932-001 and 150128-001 on units shipped after 1/75.				
		††NOTE 2: Order kit Q-758113-091 to modify old-style floor locks (units shipped before 7/73).				
		†NOTE 3: Order kit Q-755380-091 to convert tables without oilite bearings (units shipped before 4/74).				

FIG & INDEX NO.		PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
Sheet 2 of 2							
8-40-	33	3097-041	NUT, Hex .....	2	2	2	
	34	10585-041	SETSCREW, 10-32 x 1/4 (Units Shipped Before 2/72) .....	1	1	—	
	35	13397-041	NUT, Hex .....	4	4	4	
	36	16261-091	KEY, Woodruff .....	3	3	3	
	37	19680-041	LOCKWASHER .....	10	10	10	
	38	19681-045	LOCKWASHER .....	4	4	4	
	39	31820-091	RING, Retaining .....	2	2	2	
	40	31838-042	SCREW, Hex Head .....	10	10	10	
	41	93313-001	CASTER, Swivel .....	—	4	4	
		36584-091	CASTER (Includes 758693) .....	4	—	—	
	42	758693-091	• WHEEL .....	4	—	—	
	43	38968-061	PIN, Roll .....	1	1	1	
	44	40006-061	SETSCREW, 1/4-20 x 5/16 .....	3	3	3	
	45	47777-091	SPRING .....	1	1	1	
	46	47939-061	STUD, 1/4-20 x 3 .....	1	1	1	
	47	55084-010	SHAFT .....	1	1	1	
	48	55088-091	LATCH, Floor Lock .....	1	1	1	
	49	55284-004	NAMEPLATE, — LOCK .....	1	1	1	
	50	77519	PIN, 1/2 x 1-5/16 (Units Shipped Before 2/72) (Sub: 79878-001) .....	1	—	—	
	51	77521-091	BEARING, Floor Lock .....	2	2	2	
	52	77524-045	SHAFT, Floor Lock .....	1	1	1	
	53	77729-045	SPACER .....	2	2	2	
	54	77731-001	CAM, Lift .....	2	2	2	
	55	78203-091	BEARING .....	3	3	3	
	56	79539-010	SCREW, Flat Head .....	3	3	3	
	57	79878-001	PIN, Groove (Units Shipped After 2/72) .....	1	1	1	
	58	80117-091	SPRING .....	1	1	1	
	59	80196-045	SETSCREW, Nylok, 7/8-14 x 1-1/4 .....	1	1	1	
	60	83745-001	SPACER .....	—	4	4	
	61	83746-001	SHIM .....	—	4	8	
	62	133681-010	PEDAL, Lock .....	1	1	1	
	63	133687-010	CAP, Pedal .....	1	1	1	
	64	134063-017	LATCH, Floor Lock .....			1	
	65	134063-018	LATCH, Floor Lock .....			1	
	66	146289-001	BASE .....			1	

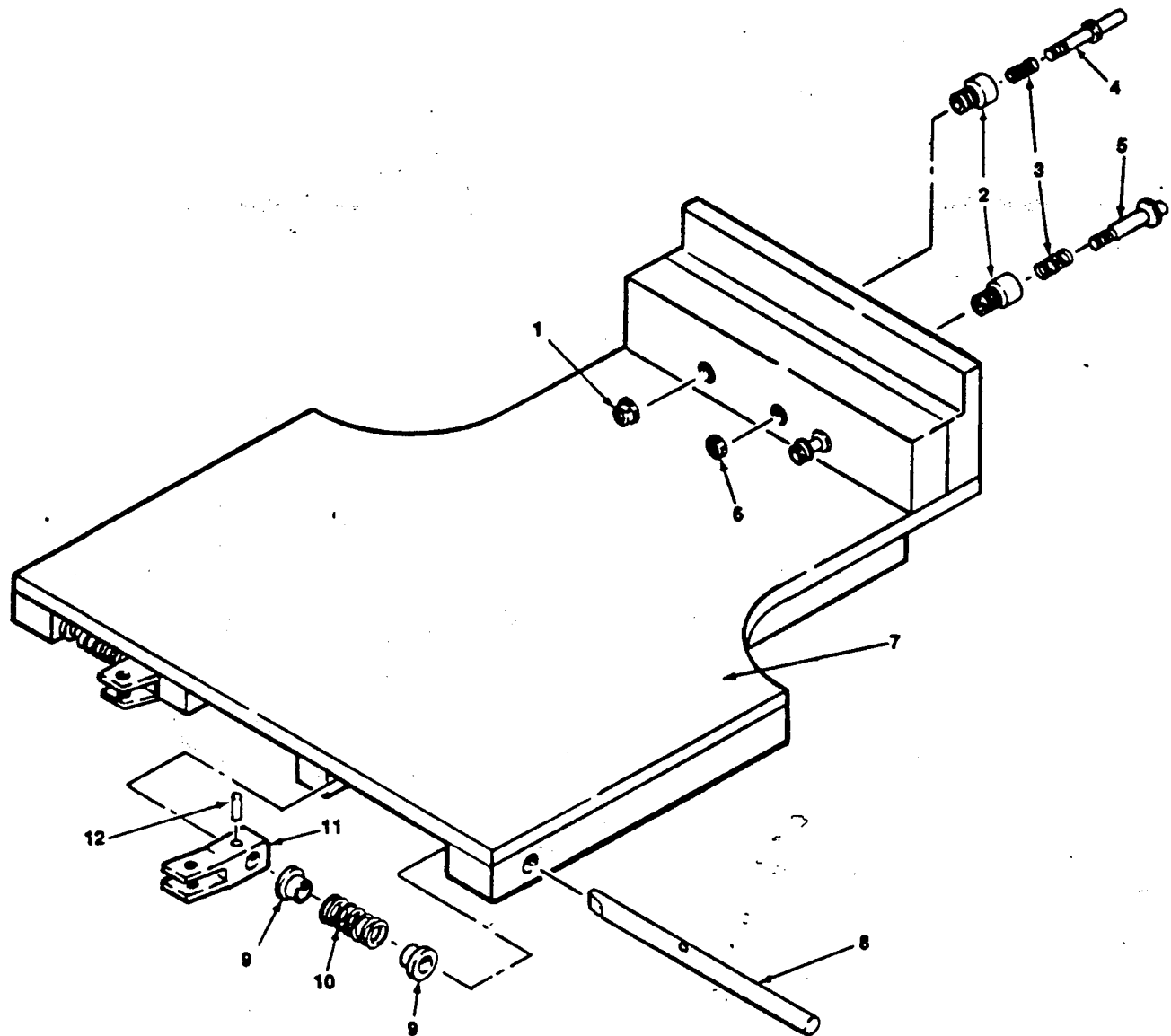


Figure 8-41. 2080 COMPAT LOCKING DEVICE (Sheet 1 of 2).

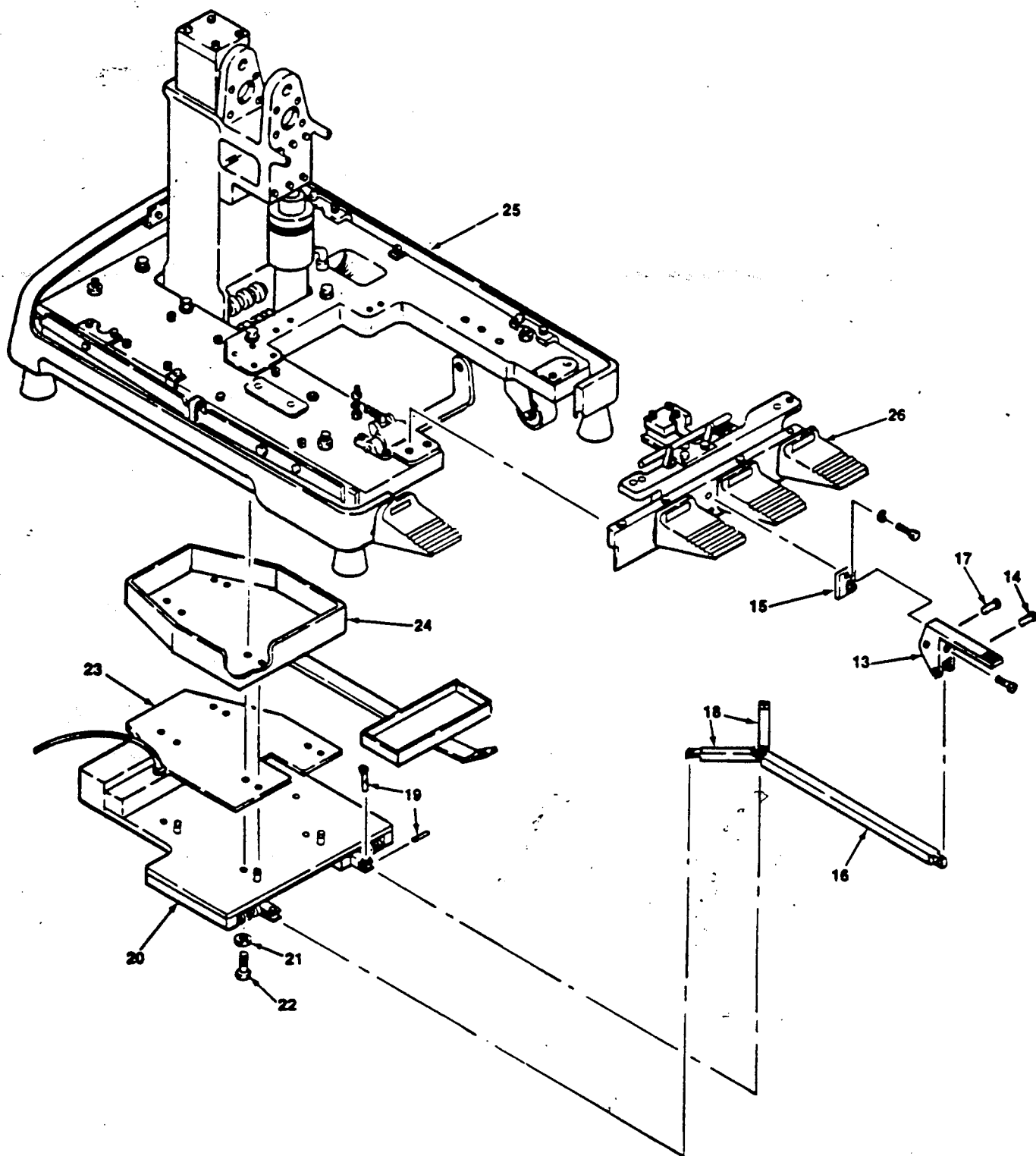


Figure 8-41. 2080 COMPAT LOCKING DEVICE (Sheet 2 of 2).

FIG. & INDEX NO.	PART NUMBER			DESCRIPTION	UNITS PER ASSEMBLY			
		AMSCO	ADMI					
8-41-	P	143135	001	LOCKING DEVICE				
Sheet 1 of 2								
1	P	143135	009	B-9816 NUT, Contact .....	2			
2	P	143135	023	B-9815 SLEEVE, Stop Pin .....	3			
3	P	143135	024	B-5330 SPRING, Compression .....	3			
4	P	143135	022	B-9814 BOLT, Contact .....	2			
5	P	143135	010	ROD, Grounding (Strack-Norm 2300/1) .....	1			
6				NUT, M2 x 10 DIN 1481 .....	1			
7				C-181-37 PLATE, Locking .....	1			
	P	143135	025	C-181-26 PLATE, Locking .....	1			
8	P	143135	014	B-7143 BOLT, Locking .....	2			
9	P	143135	015	B-7144 BUSHING, Guide .....	4			
10	P	143135	016	B-1650 SPRING, Compression .....	2			
11	P	143135	017	B-7443 HINGE, Spring .....	2			
12				PIN, M5 x 20 DIN 1481 .....	2			

FIG. & INDEX NO.	PART NUMBER			DESCRIPTION	UNITS PER ASSEMBLY		
	AMSCO		ADMI				
					Sheet 2 of 2		
8-41-13	P	143135	004	C-181-30	PEDAL, Release .....	1	
14	P	143135	007	B-9810	BOLT, Hinge .....	1	
15	P	143135	005	B-9696	PEDESTAL, Bearing .....	1	
16	P	143135	008	B-9694	SHAFT, Pedal .....	1	
17	P	143135	006	B-9811	BOLT, Hinge .....	1	
18	P	143135	003	B-7442	STRADDLING, Hinge .....	2	
19	P	143135	002	B-8858	HINGE, Bolt .....	2	
20				C-181-37	PLATE, Locking (See Fig. 8-41 Sheet 1 of 2) .....	1	
21		10470	061		LOCKWASHER .....	4	
22		36633	051		SCREW, 3/8-16 x 1-3/4 .....	4	
23		93270	001		GASKET, Oil Pan .....	1	
24		136243	001		DRIP PAN ASSEMBLY, Oil (See Fig. 8-28) .....	1	
25		146199	001		BASE ASSEMBLY (See Fig. 8-28) .....	1	
26		146200	001		PEDAL ASSEMBLY (See Fig. 8-37) .....	1	

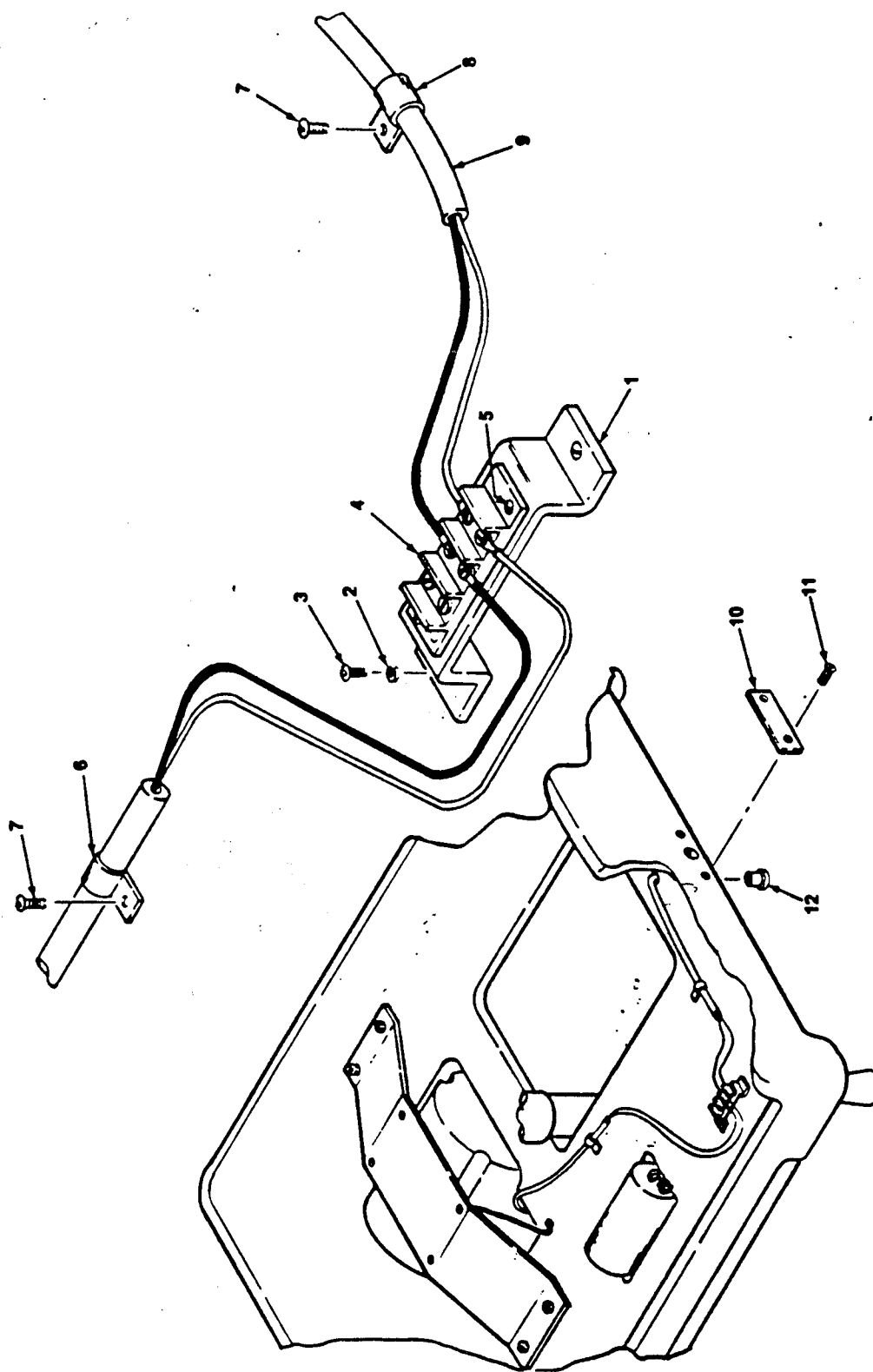


Figure 8-42. 2080 COMPAT BASE ELECTRIC COMPONENTS ASSEMBLY.



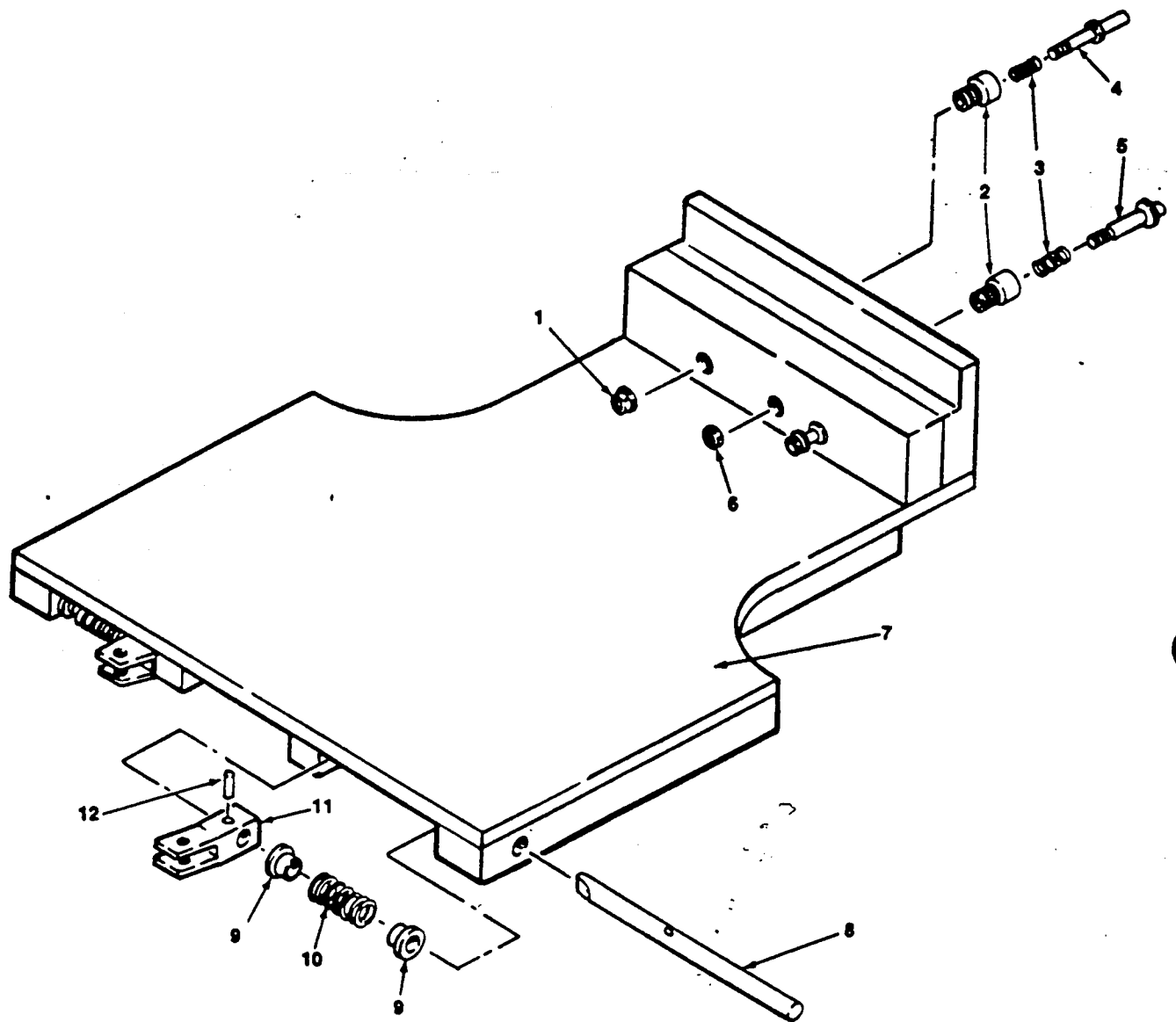


Figure 8-41. 2080 COMPAT LOCKING DEVICE (Sheet 1 of 2).

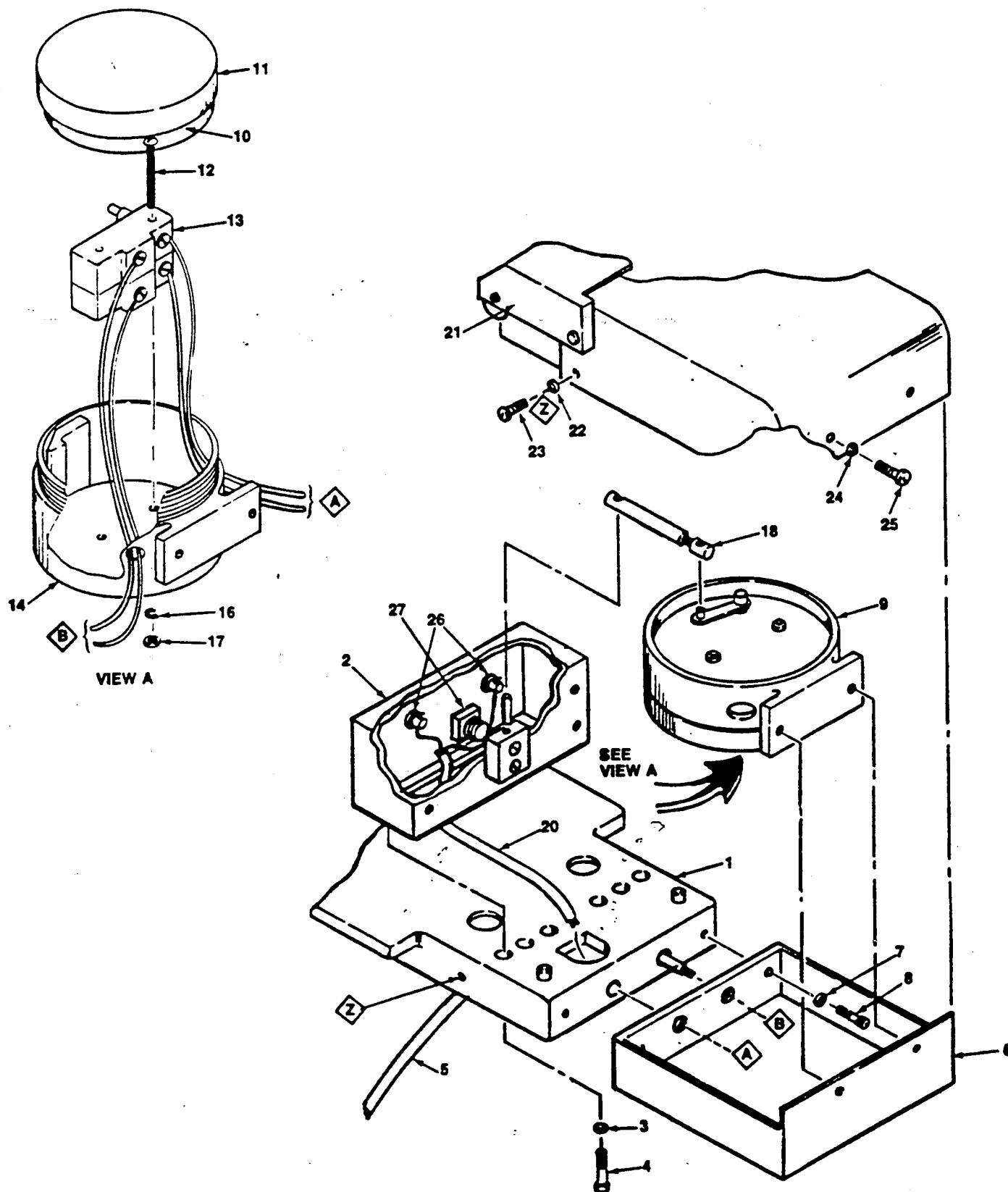


Figure 8-43. FIXED PIVOT ADAPTOR (Sheet 1 of 2).

FIG. & INDEX NO.	PART NUMBER			DESCRIPTION	UNITS PER ASSEMBLY		
	AMSCO		ADMI				
8-41-	P	143135	001	LOCKING DEVICE			
Sheet 1 of 2							
1	P	143135	009	B-9816 NUT, Contact .....	2		
2	P	143135	023	B-9815 SLEEVE, Stop Pin .....	3		
3	P	143135	024	B-5330 SPRING, Compression .....	3		
4	P	143135	022	B-9814 BOLT, Contact .....	2		
5	P	143135	010	ROD, Grounding (Struck-Norm 2300/1) .....	1		
6				NUT, M2 x 10 DIN 1481 .....	1		
7				C-181-37 PLATE, Locking .....	1		
	P	143135	025	C-181-26 PLATE, Locking .....	1		
8	P	143135	014	B-7143 BOLT, Locking .....	2		
9	P	143135	015	B-7144 BUSHING, Guide .....	4		
10	P	143135	016	B-1650 SPRING, Compression .....	2		
11	P	143135	017	B-7443 HINGE, Spring .....	2		
12				PIN, M5 x 20 DIN 1481 .....	2		

FIG. & INDEX NO.	PART NUMBER			DESCRIPTION	UNITS PER ASSEMBLY			
	AMSCO		ADMI					
8-43-	P	143136	001	FIXED PIVOT ADAPTOR .....	X			
				Sheet 1 of 2				
1			C-181-4	PIVOT BLOCK .....	1			
2			C-100-269	CONTACT BOX ASSEMBLY .....	1			
3				WASHER 6 DIN 7980 .....	4			
4				SCREW M6 x 20 DIN 912 .....	4			
5	P	93274	001	HARNESS, Wire .....	1			
6			C-181-5	BOX .....	1			
7				WASHER 8 DIN 7980 .....	2			
8				SCREW M8 x 2 DIN 912 .....	2			
9	P	143132	010	C-182-4 SWITCH HOUSING .....	1			
10	P	93340	001	INSULATOR .....	1			
11			B-7152	COVER .....	1			
12	P	83553	001	SCREW .....	2			
13	P	83668	001	SWITCH, Micro .....	2			
14	P	93340	002	INSULATOR .....	1			
15	P	83670	001	BUSHING, Snap .....	2			
16	P	19675	041	LOCKWASHER .....	2			
17	P	3037	041	NUT .....	2			
18			B-9262	ARMATURE .....	1			
19			B-9261	PIN .....	1			
20	P	93223	003	HARNESS, Wire .....	1			
21				COVER, Contact .....	1			
22				WASHER 4 DIN 7980 .....	2			
23				SCREW M4 x 8 DIN 84A .....	2			
24				WASHER 5 DIN 7980 .....	2			
25				SCREW M5 x 15 DIN 6912 .....	2			
26				CONTACTS, Power (Fixed) .....	2			
27				CONTACT, Ground .....	1			

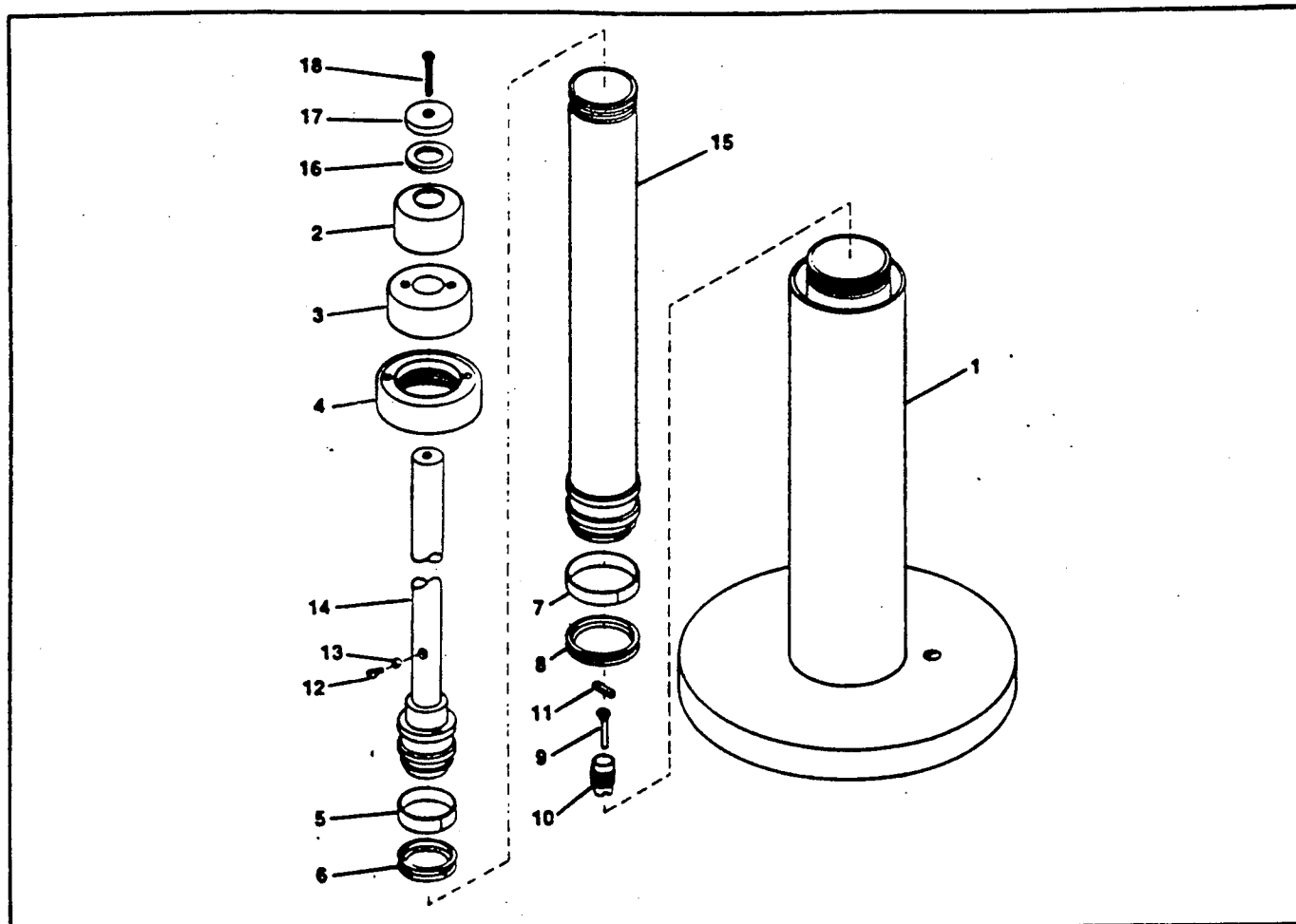


Figure 8-44. LIFT CYLINDER ASSEMBLY; UNITS SHIPPED AFTER 7/77

FIG. & INDEX NO.	PART NUMBER			DESCRIPTION	UNITS PER ASSEMBLY			
	AMSCO	ADMI						
8-44-	P	136375	001	LIFT CYLINDER ASSEMBLY (Units Shipped After 7/77)	1			
	P	763909	002	LIFT CYLINDER ASSEMBLY (Rebuilt)	1			
1				CYLINDER AND BOTTOM PLATE ASSEMBLY .....	1			
2				SPLASH CUP ASSEMBLY .....	1			
3				CAP, Small Cylinder .....	1			
4				CAP, Large Cylinder .....	1			
5				STRIP .....	1			
6				SEAL, Polypak .....	1			
7				STRIP .....	1			
8				SEAL, Polypak .....	1			
9				BALL VALVE .....	1			
10				RETAINER BALL .....	1			
11				GATE, Ball Valve .....	1			
12				SCREW, Button Head (4-40 x 1/4) .....	1			
13				O-RING .....	1			
14				PISTON ROD ASSEMBLY .....	1			
15				CYLINDER ASSEMBLY .....	1			
16				WASHER, Spring .....	1			
17				WASHER, Piston-Rod .....	1			
18				SCREW, Flat Head .....	1			

FIG & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY			
8-45-	146645-510	TABLETOP ASSEMBLY, 2080 I.A. RC .....	X			
1	3902-041	SCREW, Hex Head, 3/8-16 x 1 .....	2			
2	3949-042	SCREW, 1/4-20 x 3/4 .....	4			
3	8873-045	PIN, Tube Link .....	2			
4	9282-041	SCREW, Flat Head, 10-32 x 3/8 .....	2			
5	9645-061	SCREW, Drive, 4 x 3/16 .....	2			
6	12451-041	SCREW, Machine, 6-32 x 1/4 .....	4			
7	15220-045	GEAR, Spur .....	2			
8	15324-042	SCREW, Machine, 1/4-20 x 3/8 .....	2			
9	16197-045	BUSHING, Eccentric .....	4			
10	16201-091	WASHER, Thrust .....	2			
11	16212-042	LOCKNUT .....	4			
12	16215-091	PIN .....	2			
13	16235-045	BUSHING .....	2			
14	16247-091	GEAR, Worm .....	1			
15	16284-042	STABILIZER .....	1			
16	16285-042	BEARING .....	1			
17	16299-091	WASHER .....	2			
18	16395-091	WASHER, Thrust .....	2			
19	16438-042	WASHER, Shaft .....	2			
20	16578-045	WASHER .....	A/R			
21	19684-061	LOCKWASHER .....	4			
22	20197-045	SPACER .....	A/R			
23	56397-015	ELEVATOR, Kidney .....	1			
24	24700-061	PIN, Groove .....	3			
25	25834-091	SETSCREW .....	6			
26	26577-002	BUTTON, Plug .....	2			
27	43337-063	PIN, Hinge .....	2			
28	44440-063	PIN, Hinge .....	2			
29	44766-091	BEARING, Thrust .....	2			
30	52715-091	SPACER .....	1			
31	52716-091	SPACER .....	1			
32	53328-042	BOX, Gear .....	1			
33	55100-091	SEAT SECTION ASSEMBLY (See Fig. 8-8) .....	1			
34	146645-216	LEG SECTION ASSEMBLY (See Fig. 8-7) .....	1			
35	55105-091	BACK SECTION ASSEMBLY (See Fig. 8-9) .....	1			
36	55114-001	BACK SECTION LEVER ARM ASSEMBLY (See Fig. 8-13) .....	1			
37	136800-702	LEG SECTION LEVER ARM ASSEMBLY (See Fig. 8-46) .....	1			
38	76253-063	SHAFT, Cross .....	1			
39	77555-091	SLEEVE .....	4			
40	77559-056	KNOB ASSEMBLY .....	2			
41	77730-061	BAR, Gear Rack .....	2			
42	78200-052	LINK .....	2			
43	78316-042	RACK .....	2			
44	150092-001	LOCKNUT .....	2			
45	133688-001	HEADREST ASSEMBLY (See Fig. 8-10) .....	1			
46	129357-095	SCREW, Flat Head Socket, 5/16-18 x 1-1/4 .....	2			
47	129357-092	BEARING, Sleeve, 5/16 I.D. x 7/16 O.D. x 7/16 .....	2			

Figure 8-46. LEG SECTION LEVER ARM ASSEMBLY (2080 I.A. TABLE).

LEG SECTION LEVER ARM ASSEMBLY (2080 I.A. TABLE).			
FIG & INDEX NO.	PART NUMBER	DESCRIPTION	UNITS PER ASSEMBLY
8-46-	136800-702	LEVER ARM ASSEMBLY — 2080 I.A. TABLE	X
1	16266-063	PIN, .498 Dia. x 1-1/4	2
2	15300-041	PIN, Taper, #6 x 1-3/4	2
3	136800-693	LEVER ARM, Lower, R.H.	1
4	136800-696	LEVER ARM, Lower, L.H.	1
5	16218-061	SHAFT	1
6	8301-091	KEY, Woodruff, #808, 1/4 Thk. x 1	1
7	26028-091	NUT, Stop, 5/16-18	1
8	15014-091	WASHER, .628 I.D. x 1-1/4 O.D. x 1/8	1
9	16108-091	GEAR, Worm	1
10	16201-091	WASHER, Thrust, 1-1/64 I.D. x 2 O.D. x 1/8	1
11	16918-041	SCREW, Set, #10-32 x 3/8	1
12	93902-112	LEVER ARM, Upper, R.H.	2
13	93902-115	LEVER ARM, Upper, L.H.	1